

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002347**Date Inspected:** 10-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Closed Rib Deck Panel	NA	NA	Welding

OBG Bay 1: Caltrans QA observed ZPMC shop workers performing fitup and tack welding, closed u-ribs to deck plate, assembly identified as DP462-001. The tack welders were identified as Mr. Sheng Qizhen, welder stamp #059401 and Mr. Tang Ke, welder stamp #062305, utilizing welding procedure WPS-B-T-2342-U2 (rib), revision 0. . Caltrans QA measured current welding parameters at approximately 335 amps, 30.3 volts and 545mm/min (millimeters per minute) travel speed. Caltrans QA also observed ZPMC welder welding closed u-rib complete joint penetration (CJP) splice weld, subassembly u-rib identified as DP462-001-194 and DP381-001-190 191. The welder is identified as Mr. Song Yin Shu, welder stamp #059421, utilizing welding procedure WPS-B-T-2233-B-U2-F, revision 1. Caltrans QA measured current welding parameters at approximately 210 amps, 25.0 volts and 108mm/min (millimeters per minute) travel speed. Caltrans QA observed ZPMC QC/CWI inspector, Mr. Chen Xi monitoring the welding activities at the workstations. The following digital picture illustrates fitup and tack welding closed ribs to deck plate.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As identified within the contents of this report.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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