

**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-002417**Date Inspected:** 19-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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 Deck panels**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at weld joint for the SSD 019A floor beam (FL-2-1) at the junction of stiffeners to bottom flange weld joints 10, 22, 34 and 42, SEG020A-014 (at the junction of side plate SP67 to SP79), SEG-020A-021 (at the junction of side plate SP-56A and SP68A) and SEG020A-026 (at the junction of side plate SP-68B and SP80B). The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL\_6027 generated on this date.

The QA inspector performed ultrasonic testing for information purposes on the weld joint for SEG-16-008 at the junction of the side plate and bottom plate SP-030 to BP-012 and on SEG 017A-004 at the junction of the side plates SP-014-and SP-015. The QA inspector concurred with ZPMC evaluations. However rejectable indications present in the connection for Segment 016 appeared to be due to weld geometric, weld defects and locations in between supports where ZPMC does not have access to grind or repair.

The QA inspector witnessed the ZPMC performing UT to the weld joint on SEG-17A-004 at the junction of the side plates SP-014 and SP-015; the QA inspector found that ZPMC verifications appears to be in compliance of contract documents

**Summary of Conversations:**

The QA inspector did not have any relevant conversations.

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# WELDING INSPECTION REPORT

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## 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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

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