

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-002440**Date Inspected:** 14-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**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 observed ZPMC performing surveillance activities before continuing assembling the segment SEG-16A. The QA inspector observed that ZPMC still was repairing at the junction of the side plate to the bottom plate joint SEG-016-007 and 008.

The QA inspector performed ultrasonic testing (UT) 10 % UT at random locations at the completed joint penetration at weld joint SEG020A-003 (side plate connection BP-23A and BP-24A). 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 15 % UT on the partial penetration weld (PJP) after ZPMC representative verifications were completed on the deck panel DP-137-001 weld joints 1 and 10. The QA inspector concurred with ZPMC on the overall location and sizing of the areas identified with incomplete penetration. Locations with depth of penetration with less than 80 % were reported on weld # 1 and 10. See UT report TL\_6027 generated on this date.

---

---

# WELDING INSPECTION REPORT

( *Continued Page 2 of 2* )

---

---

**Summary of Conversations:**

The QA inspector did not have any relevant conversation on this date.

**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.

---

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

---