

**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-003289**Date Inspected:** 11-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

**Production Monitoring Tests Macro Etch Evaluation**

The Quality Assurance Inspector performed a visual evaluation of a production monitoring test (PMT) macro etch samples, identified as DP-413-001/DP-332-001. The PMT was welded on the previous shift. All samples appeared to contain penetration greater than 80 percent. All the data from the review was recorded in a tracking log and forwarded to Quality Assurance Task Leaders and Structural Materials Representatives. The Samples were digitally photographed and placed on the internal server for future review.

**Deck Panel DP-564-001**

The Quality Assurance Inspector performed Ultrasonic Testing to the partial joint penetration weld joining the closed rib to deck panel connection measuring the lack of penetration. The testing was performed on the tack welds of welds 1 through 3. The data was recorded in an electronic spreadsheet along with the data collected from the other welds.

**Summary of Conversations:**

As stated in the contents of the above 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

---

---

## WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

---

---

remedial efforts please contact Ady Velasco(707) 552 7715, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

---

<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer
---------------------	-------------	-------------