

**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-003320**Date Inspected:** 22-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**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, Larry Viars was present observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector observed ZPMC welder Xu Xian Ping performing Flux Cored Arc Welding (FCAW) in the 2F position on the Bottom Plate BP311-001-037 stiffener weld. The following parameters were recorded from BP311-001-037, amperage 287, volts 28.2, travel speed of 507 mm/min. The above mentioned welding appeared to be in conformance with the posted welding procedure specification, WPS-B-T-2231-U3-F-1.

The Caltrans QA performed Ultrasonic Testing Verification of ZPMC Quality Control (QC) tested and accepted Tower Diaphragm CJP welds SSD1-SA335- 1A (1B) and 9A (9B). Testing of the 75 mm diaphragm CJP weld was performed from face A with a 70 degree transducer for the bottom quarter and middle half in the first leg. Testing of top quarter was performed with a 45 degree transducer in the second leg. Diaphragm welds tested appeared to meet the requirements of AWS D1.5 (2002) table 6.3. Please see UT report TL-6027 generated on this date for further information.

The Caltrans QA performed Ultrasonic Testing Verification of ZPMC Quality Control (QC) tested and accepted OBG Floor beam CJP welds FB009-009-045, FB012-009-043 (R2), FB016-009-045, FB011-003-045, FB011-007-045 and FB016-012-045. Ultrasonic testing was performed from face A & B in the first and second leg with a 70 degree transducer. No relevant indications were noted during verification. Please see UT report TL-6027 generated on this date for further information.

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**Summary of Conversations:**

No relevant conversations occurred 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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