

**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-003543**Date Inspected:** 01-Aug-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:** Tower and 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 layout, cutting, beveling, milling, fitting and welding activities in bay # 1 and 2 on Tower Assembly shop.

**Ultrasonic testing**

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the floor beam SSD14 PP025 weld joints # 131 thru 008 and floor beam SSD13, PP024 welds joints # 010 to 044. The QA inspector performed 10 % UT at random location. 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 (UT) at the completed joint penetration at the floor beam for the 3B-W weld joints # SEG-15B-027 and SEG-015B-036. The QA inspector performed 10 % UT at random location. 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.

**Tower Bay #8****Skin C East lift # 1**

The QA inspector witnessed ZPMC UT technician Dai Geng Sheng performing ultrasonic verifications at the Tower diaphragm ESD1-SA226 weld joint 10 A and 10B after heat straightening. The QA inspector observed that the UT technician did not scan searching for transverse indications. Mr. Dai made corrections after the QA inspector brought to his attention.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

**Summary of Conversations:**

As noted above.

**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 Ady Velasco, 858 344-8746, who represents the Office of Structural Materials for your project.

---

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

---