

**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-004025**Date Inspected:** 23-Sep-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:** Name not obtained**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 diaphragm assemblies**Summary of Items Observed:**

Tower shop - Bay 2

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed random final VT on double diaphragm assemblies ESD1-23M and ESD1-18M. QA Inspector observed undercut at or exceeding 1mm in depth in various web to web and web to diaphragm welds. ABF QC Don Walton (ABF QC) was informed and ABF QC replied that ZPMC would make the necessary welding repairs to conform to AWS D1.5 and contract documents. No other indications were observed. Caltrans Quality Assurance Inspector's Joselito Lizardo and Tim McClendon were present and performing random final MT and final VT also. The final VT was not accepted by Caltrans inspectors on this day. Also present in this bay were ABF QC's Zhang Da Ming, Mike Williams, and C. K. Chan. Items observed appeared to comply with project specifications.

**Summary of Conversations:**

As noted above in Summary.

**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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

**Inspected By:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Carreon, Albert

QA Reviewer