

**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-010530**Date Inspected:** 25-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG	

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**Blast Shop #1**

This QA Inspector and Caltrans QA Inspector Mr. Utaker performed random visual inspections of the interior upper surfaces of OBG Segment 7DE. ZPMC had just completed grit blasted of these areas and the steel surfaces are now mostly free of rust oxide and other contaminants that had previously obscured portions of the plate surfaces and welds. This QA Inspector visually observed approximately 50 locations that require grinding or welding to resolve visual weld spatter, arc strikes, shallow nicks and other minor surface rejections. The areas were marked with colored chalk and ZPMC has several workers using grinders to remove the visually unacceptable areas and ZPMC has assigned a magnetic particle (MT) inspector to perform MT of the arc strike removal areas.

This QA Inspector performed random ultrasonic inspections weld repairs on OBG top deck plate butt weld OBW1-001 repair areas as referenced on NDE request 11132009-1. These ten weld locations had initially been ultrasonically rejected by ZPMC reference UT report UT-1W-015 dated 11-06-2009, and have now been repaired and accepted by ZPMC personnel. This butt weld joins OBG segment 1AAW to segment 1AW. This QA

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Inspector utilized “A”, “B”, “C” and “E” ultrasonic scans with a 70 degree transducer for detection of planar transverse indications and the weld repair areas appear to comply with project specifications.

**Summary of Conversations:**

See 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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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