

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010560**Date Inspected:** 06-Dec-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**CWI Name:** See Below**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 and Tower**Summary of Items Observed:**

CWI Inspector: Mr. An Qing Xiang

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:

## Tower Bay 11

This QA Inspector observed ZPMC welder Mr. Zhao Guiting, stencil 040723 is using flux cored welding process to add a butting weld to extend the length of East tower lift tower "B" skin splice plate that is to be connected between tower lift 2 and lift 3. This QA Inspector observed a welding current of approximately 200 amps and 23 volts and ZPMC QC personnel have a weld repair document that lists this weld as ESD1-SPSA3-63. This QA Inspector observed Mr. Zhao Guiting is certified to make this weld and ZPMC is using a torch to preheat and maintain the base material prior to making these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wu Jinguo, stencil 049541 is using flux cored welding process to add a butting weld to extend the length of East tower lift tower "B" skin splice plate that is to be connected between tower lift 2 and lift 3. This QA Inspector observed a welding current of approximately 210 amps and 26 volts and ZPMC QC personnel have a weld repair document that lists this weld as ESD1-SPSA3-63. This QA

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## WELDING INSPECTION REPORT

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Inspector observed Mr. Wu Jinguo is certified to make this weld and ZPMC is using a torch to preheat and maintain the base material prior to making these welds. Items observed on this date appeared to generally comply with applicable contract documents.

Tower Bay 10

ZPMC issued "Inspection Notification Sheet" number 4808 informing QA that ZPMC has completed ultrasonic inspections of South Tower Lift 4 skin D to skin E corner back fill plate weld complete joint penetration welds. This QA Inspector performed ultrasonic inspections of approximately 50 percent length of the following welds: SSTL4-1H/L-89, SSTL4-1I/L-20, SSTL4-1I/L-87, SSTL4-1J/L-18, SSTL4-1J/L-88, SSTL4-1L/K-20 and SSTL4-1L/K-87. This QA Inspector observed ZPMC QC personnel had previously marked these welds as being ultrasonically accepted. Items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

### **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
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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