

**DEPARTMENT OF TRANSPORTATION**  
 DIVISION OF ENGINEERING SERVICES  
 Office of Structural Materials  
 Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4  
 Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6  
 File #: 69.28

**WELDING INSPECTION REPORT**

**Resident Engineer:** Pursell, Gary  
**Address:** 333 Burma Road  
**City:** Oakland, CA 94607

**Report No:** WIR-000823  
**Date Inspected:** 05-Nov-2007

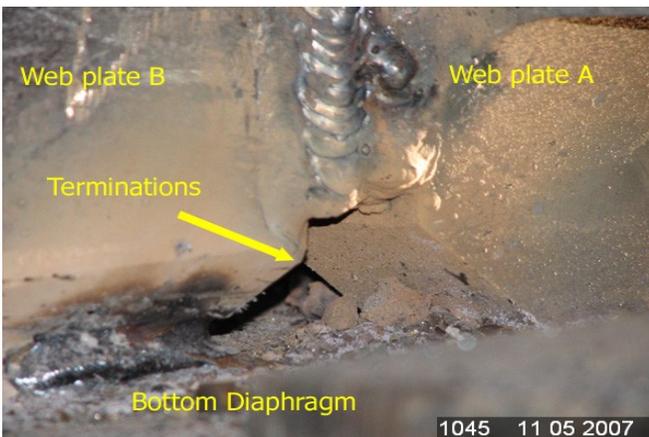
**Project Name:** SAS Superstructure **OSM Arrival Time:** 630  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1530  
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Lefeng	<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>	Tower Mock-up 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.

Item Description	WBS	Dwg No.	Status
1 89 Mock-up Assembly- MUB1			
The QA inspector performed random visual inspection to the weld terminations at the mock-up areas. QA inspector observed that welds joint web plate to web plate was being terminated as shown on the photograph below.			



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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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2 Cutting operations at the Flange Reinforcement ring SA-273 Tower Mock-up 77 M

The QA inspector observed ZPMC performing oxyfuel cutting operations to the run on tabs located at end of the weld joint 1 thru 5 for the flange reinforcement ring SA-273.



3 OBG Material Verification at the ZPMC cutting table

The QA inspector verified the material being cut A-709M-345T2-X for the plate designated as X21-X21-A versus the shop drawings. The QA inspector found that the material cut appeared to be in accordance with the contract drawings.

4 OBG Milling operations plate X94-A

The QA inspector observed ZPMC milling operations on the bevel preparation for the plate for the OBG X94-A.



5 OBG Bottom deck Tees open ribs for the panel PL42A

The QA inspector observed ZPMC moving the bottom deck panel PL42A, to the Gantry welding table on shop # 3 and making set-ups of the welding machine before being welded.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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

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