

**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-001007**Date Inspected:** 07-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<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:**

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Scott Croff performing fabrication inspection out on the shop floor today. In Bay 2 Mr. Croff observed non-approved quality control personnel monitoring welding on the lower half of the 114 Meter Mock-Up assembly. Further he observed the excavating of critical weld repair (CWR) 029 on SA-24. In Bay 3 observations were made of the fitting and tacking of stiffeners on side plates and welding of bottom plate butt splices. In Bay 7 Mr. Croff observed the fitting and tack welding of floor beam diaphragm plates.

OBG

This Quality Assurance Inspector recorded the Zhenhua Port Machinery Co., Ltd. (ZPMC) ultrasonic lack of penetration measurements on the Orthotropic Bridge Girder (OBG) Closed U-Rob Weld Trial Number 2 for welds 1 through 10. This Quality Assurance Inspector further observed the dye stamping of the quality assurance selected locations for macro etched specimens on the closed u-rib welds 3 through 10.

**Summary of Conversations:**

No conversations held today.

**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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# WELDING INSPECTION REPORT

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