

**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-001098**Date Inspected:** 28-Dec-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**CWI Name:** Lu Jian Ping**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 Mock-up**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 |
|------------------|-----|---------|--------|
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|---|--|--|--|
| 1 | UT PJP U-ribs verifications Deck Mock-up |  |  |
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The QA Inspector performed Ultrasonic testing (UT) at the Deck Mock-up partial penetration joint at the junctions of the U-ribs to the deck after ZPMC completed their verifications. The QA inspector had a conversation with ZPMC representative Li Li Ming. Mr. Li notified to the QA inspector that the correction factor was 0.8 mm. The correction factor is the statistic UT value after comparing: 1. The UT values from the calibration of UT instrument with the EDM notches on ZPMC's calibration blocks, 2. The UT lack of penetration (LOP) results at the actual pieces; 3. The LOP measured after breaking the weld of the rib.

The QA inspector followed ZPMC's UT procedure (this procedure has not been approved). The QA inspector completed the UT verifications at the locations marked by ZPMC with LOP at U-rib 03 weld # 6, U-04 welds # 7 and 8, U-05 weld # 9, U-10 weld # 9, U-9 welds # 7 and 8, U-8 weld # 6. The test was in process at the end of the shift.

Results will be provided after the test completion.

**Summary of Conversations:**

As noted above.

**Comments**

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## WELDING INSPECTION REPORT

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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>  | Carreon,Albert | QA Reviewer                 |

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