

**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-001220**Date Inspected:** 15-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 100**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>	77 & 114 Meter Mock-Up	

**Summary of Items Observed:**

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, and Gabriel Quintana performing fabrication inspection out on the shop floor today. Mr. Stovall observed welding in the New Tower Bay on the 89 Meter Mock-Up. Welding joint number 5 between MUSB-MA22 Skin Plate 'D' and MUSB-MA38 Skin Plate 'E' was supposed to be MWT92 requiring a zero millimeter root opening. This was a non-standard qualified joint which is TC-U5-GF & S in the ASW D1.5 Welding Code. It was found to be ranging as high as 5.2 millimeters from the 'B' side of the weld. It appears that MWT92 gives a root opening of zero millimeters and the code allows a +2mm and a -0mm. Welding was also observed by Mr. Stovall on MUB-MA21-G/J-2A between skin plates A & B. Mr. Quintana witnessed welding in the new tower bay shop on the same pieces as Mr. Stovall and also witnessed welding on the 77 Meter Mock-Up in Bay 2 on MUA-MA1 D/F 17B between plate skins D and E.

**Summary of Conversations:**

No conversations noted.

**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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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

**Reviewed By:** Cochran, Jim

QA Reviewer