

**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-001399**Date Inspected:** 01-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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 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.

**Bay I (OBG Deck)**

The QA inspector observed that ZPMC was performing milling operations of the edges of the U-ribs plates, drilling holes with the bush hardened template at the ends of the U-ribs, bending the U-ribs to their final shape. The QA inspector had a conversation with ZPMC QC inspector Mr. Fu Yu Hong. Mr. Fu Yu Hong informed to the QA inspector that ZPMC was going to perform the Production Monitoring Test for ZPMC first deck panel. Caltrans representative Larry Viars and the QA inspector performed random dimensional verifications on the three test coupons for the production monitoring test. Dimensions (gaps and tack locations) appears to be in compliance with the contract documents. Later, Mr. Fu Yu Hong informed that the ZPMC production supervisor said that the production welding on the closed ribs has been postponed after the Chinese New Year.

**Bay II (Tower Mock-up)**

The QA inspector observed that ZPMC was performing drilling operations without hardened bushing template on the Tower splice Mock-up 114 upper skin B.

The QA inspector observed no fabrication activities on the Tower Mock-up 77 M on this date.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Tower Shop (Tower Mock-up 89 M)

The QA inspector did not observed any fabrication activities on this bay.

The QA inspector had a conversation with the QC representative Mr. Zhang Jiadi. The QA inspector informed to Mr. Zhang Jiadi that ZPMC started to performed drilling operations with a offset in between skins D on the 114 M Tower splice Mock-up of 5 mm. The 5 mm offset was located at the interior and exterior of the Tower splice Mock-up. The QA inspector added that the special provisions does not permit on the exterior to install filler plates to correct the offset. The QA inspector issued an incident report because ZPMC did not follow the contract documents.

### **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
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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