

**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-001588**Date Inspected:** 01-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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 & 77 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance (QA) Inspector observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

**Orthotropic Box Girder (OBG)**

This QA Inspector observed in Bay 1 the drilling of flange bolt holes on the flat closed u-rib plates and milling & machine beveling of flat closed u-rib plates for the partial penetration joints and the machining of the 2 millimeter radius on hand access holes. Plate DP058 PL14B is still on table with closed u-ribs tacked in place and no further work carried out.

This QA Inspector was called on to witness weld monitoring tests for the welding of the closed U-rib partial joint penetration (PJP) welding. On arrival to the bay ZPMC Mr. Fu Yu Hong informed American Bridge/Fluor (ABF) Inspector Mr. Warren Buhler and this QA inspector that no more welding would be carried out in Bay 1 on the close u-rib panels until after the Chinese New Years. Mr. Hong stated that ZPMC would continue to mill plate edges, machine bevels, drill bolt holes and bend close u-rib plate panels through the holidays.

This QA Inspector observed grinding of fillet welds in Bay 3 on side plate SP072-01 deck to T-stiffeners.

77 Meter Mock-Up

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# WELDING INSPECTION REPORT

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This QA Inspector observed the grinding of welds in Bay 2 between MUSA-SA104 diaphragm and Skin Plates E.

114 Meter Mock-Up

This QA Inspector observed the drilling of bolt holes in the skin plates of the upper and lower Mock-up.

Remains of bolt holes on the 114 Meter Mock-up



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

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