

**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-001599**Date Inspected:** 14-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei & Chen Xi**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**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)**

In Bay 1 this QA Inspector observed the milling of plate edges, beveling of partial joint penetration (PJP) preparations, machining of 2 millimeter radius on edges of plates and drilling of bolt holes using hardened washer guides of un-bent closed u-rib plates. This QA Inspector also witnessed the simultaneous bending of the close u-rib panels in compliance with the special provisions.

This QAI performed visual inspection (VT) on the 6 welds of Production Monitoring Test PMT for this date. Data was recorded on the "U-Ribs PMT/Production Inspection Sheet. The following is a brief of what was recorded; weld number 1 had weld roll over (OL) from Y-location 60 mm to 170 mm; weld number 2 had undercut (UC) form 0 mm to 65 mm and 770 mm to 805 mm; weld number 3 had UC form 0 mm to 75 mm; weld number 4 had UC form 0mm to 60 mm and 750 mm to 800 mm; weld number 5 had UC form 0 mm to 195 mm and 770 mm to 800mm and excess weld reinforcement and weld number 6 had UC for m770 mm to 800 mm.

**Summary of Conversations:**

No conversations held today.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

## 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.

---

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

---