

**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-001645**Date Inspected:** 20-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhu Zhong Hai, Zhao Den Sun	<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>	Tower Mock-Ups	

**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

114-meter Mock-Up, lower section, Z. P. M. C. started installing the bolted splice plates onto the welded splice plates, when attached to the Mock-Up in the vertical position.

Z. P. M. C. personnel rotated and relocated the upper section of the Mock-Up. Personnel started cutting off lifting lugs from the upper part of the Mock-Up. These areas will need to be ground and be Magnetic Particle Tested (MT).

89-meter Mock-Up, Z. P. M. C. Welder Lei Lichao--063619, Han Xiaofeng--054667, using WPS-B-T-2233-U2a-F, welded the fill passes at weld numbers MUB-MA21-J/J-(17 and 48). The QA inspector checked the amps and volts, on two (2) different welding machines, and recorded the following: 210 amps, 26.2 volts, 308 amps and 31.2 volts.

The QA Inspector witnessed Z. P. M. C. Quality Control (QC) personnel do a MT on weld numbers MUB-MA21-J/J-(17 and 48), the welds appear to meet the Contract Documents.

Z. P. M. C. personnel are drilling bolt holes in the doubler plate on Skin E.

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Z. P. M. C. personnel cut Skin plates to size, this work went on all day.



## Summary of Conversations:

The QA Inspector had no substantial conversations.

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

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