

**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-001655**Date Inspected:** 13-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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**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.

ZPMC bent 5 U-ribs plates U-9, U-5, U-4 and U-7 on this date. The QA inspector performed random dimensional verifications to these U-ribs. The QA inspector found that dimensions appeared to be in accordance with contract documents.

The QA inspector had a conversation with ZPMC representative Fu Yu Hong. Mr. Fu Yu Hong informed to the QA inspector that ZPMC found transverse and longitudinal cracks on the tack welds at the bottom plates at the junction of the Tee stiffeners to the bottom plates # BP-24-001 (16 transverse cracks), BP-22-01 (1 transverse crack and 2 longitudinal crack), BP-20-01 (5 transverse cracks). The QA inspector had a conversation with Caltrans Task Leader Robert Cuellar. The QA inspector brought to the attention of Mr. Robert Cuellar that ZPMC had cracking issued on the tack weld for the bottom plates panels above listed. The QA inspector performed random magnetic particle testing to enhance the visual examination on tack welds to the deck panel listed above. The QA inspector concurred with the areas marked by ZPMC QC inspectors.

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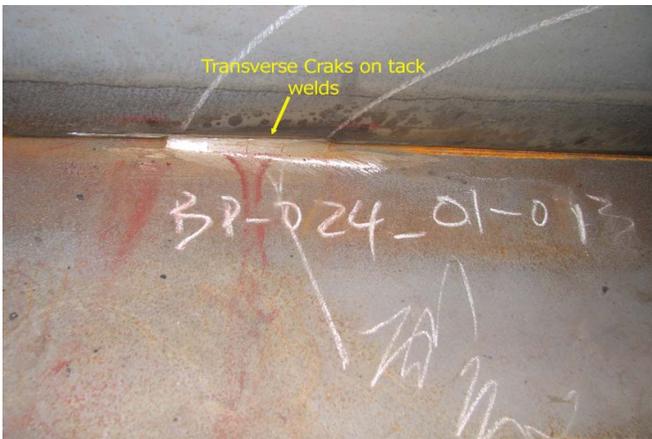
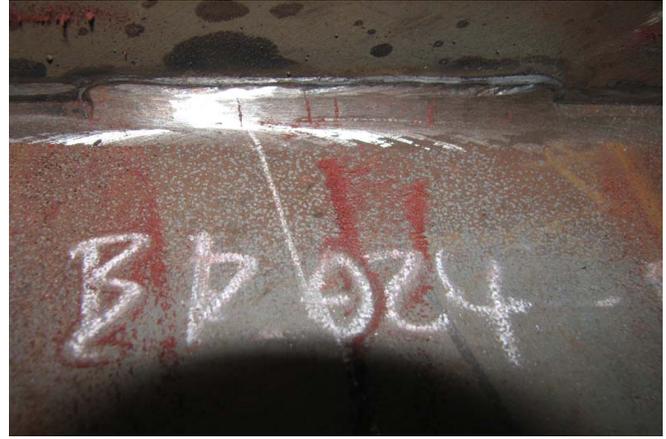
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As note 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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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer