

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001672**Date Inspected:** 04-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** 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 Inspector (QAI) 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.

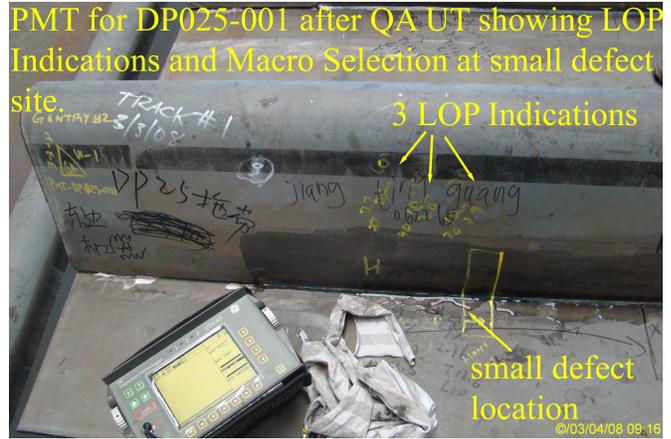
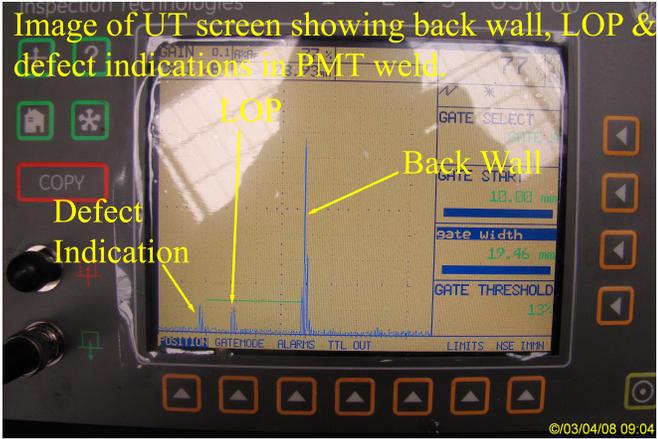
Orthotropic Box Girder (OBG)

This Quality Assurance Inspector (QAI) performed ultrasonic testing (UT) on the tack weld locations of the partial joint penetration (PJP) welds between the closed u-ribs and deck panel of DP015-001 for depth of penetration. The weld joint tested were 004 & 005. There were 5 tack weld locations with less than 9.6 millimeters (80%) penetration on weld 004 and 3 on weld 005. See ultrasonic testing report TL-6027 Modified dated March 4, 2008 for details.

This QAI performed ultrasonic testing on 3 Production Monitoring Tests (PMT) today. The first PMT was for deck plates (DP) DP070-001 & DP072-001; welds 3, 4 & 5 failed for weld penetration being between 70% & 80% and whose combined length was longer than 25mm or 5%. The second PMT was for DP025-001; welds 1 & 4 failed for weld penetration being between 70% & 80% and whose combined length was longer than 25mm or 5%. The third and final PMT was for DP027-001 & DP065-007 passed ultrasonic testing for depth of penetration. The data for all PMT's was record on the respective U-Ribs PMT/Production Inspection Sheets.

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Summary of Conversations:

No conversations held today.

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.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer