

**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-001881**Date Inspected:** 31-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	N/A	<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>	Bottom & Side Plates	

**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue 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.

89 Mock Up: QA inspector observed QC MT inspectors Mr. Zhou Dong Yun and Cai Xin Xin perform 25% minimum MT inspections on 89 mock up MUB-MA21 plate AJ welds 19 thru 38 and MUB-MA plate GJ welds 19 thru 38. During QC MT inspections indications were found on a number of welds. Mr. CAI Xin Xin informed QA inspector that welds containing indications would be MT inspected 100% of their length. Indications were marked by QC inspectors to be explored by grinding. Representative picture of indications attached. QA inspector did not perform any MT inspections due to QC inspection not complete.

New OBG: QA Inspector performed random visual and magnetic particle inspections to portions of bottom and side plate T stiffener welds on plates SP 051-001, SP 052-001, BP 011-001, BP 010-001, SP 022-001, SP 030-001, SP 062-001, SP 070-001, SP 058-001, SP 046-001, SP 057-001, SP 045-001, SP 059-001, SP 047-001, SP 073-001, and BP 026-001. Markings were found on plates BP 011-001, BP 010-001, SP 070-001, SP 058-001, SP 057-001, and SP 073-001 delineating QC MT inspections completed and accepted by Mr. Zhou Diong Yun and Mr. Cai Xin Xin. The remaining bottom and side plates inspected this day by QA MT inspector did not have a QC MT complete mark. Representative picture of QC MT mark shown in attached picture. Please see TL-6028 MT report dated 03-31-2008 for details on MT inspection.

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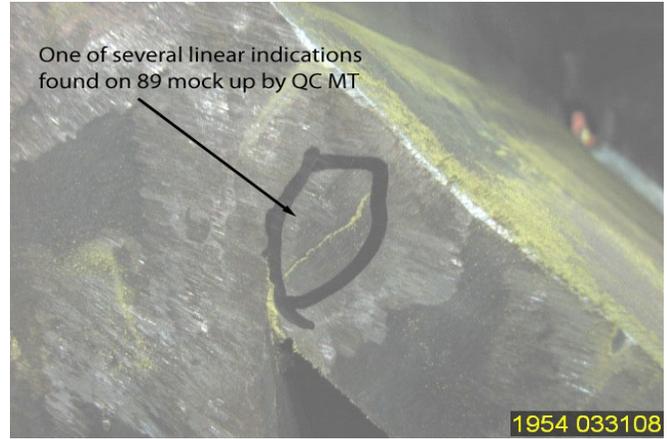
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Conversations noted in items observed 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>	Prue,Erik	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hager,Craig	QA Reviewer
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