

**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-002124**Date Inspected:** 23-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:** Tower and OBG Fabrication**Summary of Items Observed:**

Orthotropic Box Girder (OBG) and Tower Fabrication:

Bay 1

QA Inspector observed ZPMC welder Mr. Zhou Chengshuang, stencil 59400 is using welding procedure specification WPS-B-T-2233-B-U2-F to make flux cored closed rib splice weld DP327-001-156. Prior to welding the QA Inspector observed the groove area where Mr. Chengshuang was preparing to weld had been backgouged and ground to a bright metal surface. The QA Inspector observed a welding current of approximately 215 amps and 24.5 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector performed ultrasonic inspections of OBG side plate complete joint penetration groove welds SP 609-001-067 and SP 529-001-064. QA ultrasonic inspections reveal SP 609-001-067 appears to comply with project specifications and weld SP 529-001-064 has a class "A" indication. These welds had been previously accepted by ZPMC QC personnel. See the TL-6027 "Ultrasonic Test Report" dated today for additional information. The QA Inspector informed Lu Jian Hua that weld SP 529-001-064 appears to have a class "A" ultrasonic indication.

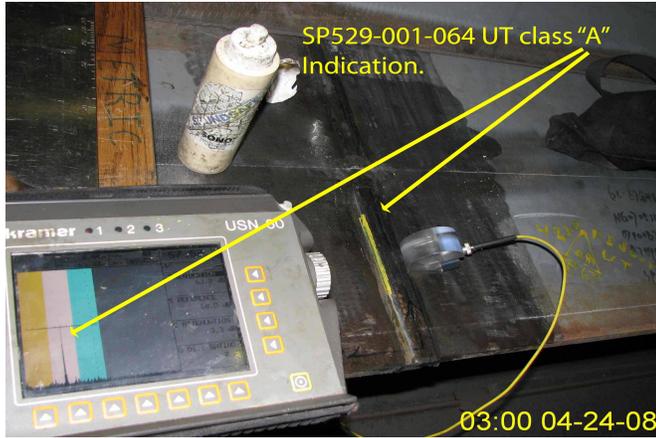
The QA Inspector performed ultrasonic inspections of OBG closed rib complete joint penetration groove welds DP 138-001-191 and DP 138-001-194. QA ultrasonic inspections reveal SP both welds appear to comply with project specifications. These welds had been previously accepted by ZPMC QC personnel. See the TL-6027 "Ultrasonic Test Report" dated today for additional information.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

See above for summary of 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 Patrick Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

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**Inspected By:** Dawson,Paul

Quality Assurance Inspector

**Reviewed By:** Carreon,Albert

QA Reviewer