

**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-002161**Date Inspected:** 21-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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.

**OBG U-ribs**

The QA inspector performed 10% ultrasonic testing (UT) on the completed joint penetration (CJP) U-ribs splice after ZPMC representative verifications on the deck panel DP-327-001 at the U-ribs splices weld joints # 154 thru 157; U-ribs #199, U-210, U-50 and U-216. The QA inspector found that the weld areas tested from side A appeared to be in general compliance with AWS D1.5 2002. See UT report TL\_6027 generated on this date.

**OBG Deck Plate**

The QA inspector performed 10 % ultrasonic testing (UT) on the completed joint penetration (CJP) after ZPMC representative verifications on the deck plate for DP-489-001 at the weld joints # 117. The QA inspector found that the weld areas tested from side A appeared to be in general compliance with AWS D1.5 2002. See UT report TL\_6027 generated on this date.

**OBG Side Plates**

The QA inspector performed 10 % ultrasonic testing (UT) on the completed joint penetration (CJP) after ZPMC representative verifications on the side plates weld joints # SP- 070A-013A-017, SP-62A-019-020, SP-075A-014-006 and SP-016-001-057. The QA inspector found that the weld areas tested from side A appeared to be in general compliance with AWS D1.5 2002. See UT report TL\_6027 generated on this date.

The QA inspector had a conversation with Caltrans Task Leader Robert Cuellar. The QA inspector brought to the

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attention of Mr. Robert Cuellar that at the junction of the longitudinal and transverse joints, the transverse weld is not ground smooth to access with the UT probe from both sides of the weld axis.

**Summary of Conversations:**

As noted 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>	Acuna,Alfredo	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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