

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-002167**Date Inspected:** 12-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Huang Wen-Panq**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:**

Floor beams UT verification

This Quality Assurance (QA) inspector arrived at ZPMC for periodic observation of the Self-Anchored Suspension Tower (SAS) and Orthotropic Bridge Girders (OBG). This QA inspector Performed Ultrasonic Examination (UT) verification in bay 7 for Floor beam components that included web plate splices that was welded with a Complete Joint Penetration (CJP) weldment for transition of 30mm thick and 12mm thick plates. The UT verification was performed after ZPMC technicians had performed their testing and had accepted the weldments and signed them off with "accept" and the technicians name on the parts tested. There were a total of 12 weldments for this fit-up that were verified by this QA inspector and QA inspector Edward Leach. Along with these Flange splices were also tested on floor beams that was accepted by ZPMC technicians. See UT report TL-6027 for locations and component numbers. ZPMC rejected 3 welds for rejectable indications they are as follows; FB015-12-26, FB026-01-21 and FB003-14-022. These welds were clearly marked for the locations on the parts and "Rej" was hand written by ZPMC UT technicians.

**Summary of Conversations:**

Spoke with CWI Huang Wen-Panq in regards to the floor beams and locations in which were ready for the QA verification. Also discussed the signing of the plates with VT accept after ZPMC has performed their visual inspection and prior to NDT. The CWI agreed that it would be done.

**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 Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hager, Craig	QA Reviewer
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