

**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-002204**Date Inspected:** 09-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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>	OBG	

**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) witnessed ultrasonic testing (UT) of a 2805mm long complete joint penetration (CJP) weld SSD1 SA159 B/J 1 sides A & B. Both sides of the weld exhibited class A indications, 4 on side 'B' and at least 1 side 'A' all found with the 45° transducer. Indications all appeared to be 10mm and less in depth on this 70mm thick plate weld. Both sides, A & B, will now need to be ground flush and re-tested after repairs. The Zhenhua Port Machinery Company (ZPMC) UT Technicians were Xue Han Yong and E Shue Qin. Xue performed all of the UT on side "B" and the 70° inspection on side 'A'. E Shue Qin performed the 45° inspection on side 'A'.

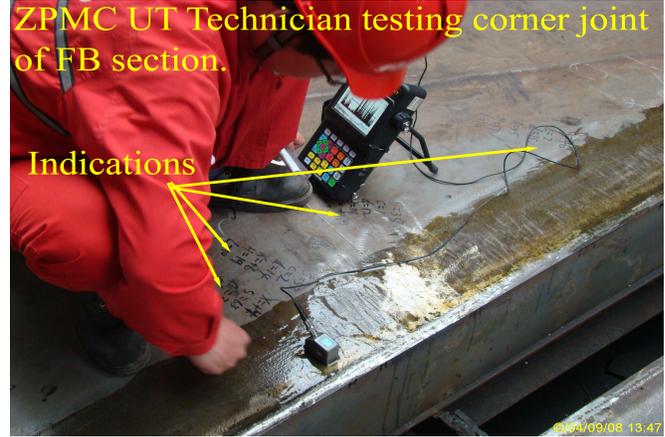
This QAI witnessed UT of a number of CJP corner welds on OBG FB-018-01, FB-018-02 & FB-026-01 with all weld containing unacceptable Class-A indications. The ZPMC UT Technicians were Li Li Ming, E Shua Qin, Xue Han Yong and Ma Ji Long for these Floor beam Sub-Assemblies.

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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

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**Reviewed By:** Hager, Craig

QA Reviewer