

**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-002257**Date Inspected:** 28-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:****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 & OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girders (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

| Item | Description                                                                                                                                                                                                                                                                                                                                                                                                                                           | WBS | Dwg No. | Status                   |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|---------|--------------------------|
| 1    | Tower Skin Plate<br>New Tower Shop Bay 1: Caltrans QA observed the beveling of the skin plate double bevels at the ZPMC horizontal milling machine. The tower skin plate is identified as P1269. Caltrans QA met with mill operator at the workstation and verified the machined bevels per work instructions at the workstation. These dimensions were referenced to the approved drawing and were in conformance with the dimensional requirements. | NA  | NA      | Machine Bevels           |
| 2    | Tower Skin Plate<br>New Tower Shop Bay 3: Caltrans QA observed ZPMC mechanical straightening of the tower skin plate, identified as P527. The plate is being straightened at the 3000 ton press. Caltrans QA observed ZPMC QC inspector, Mr. Shi Yu monitoring the straightening of the tower (longitudinal) stiffener plate. The following digital picture illustrates mechanical straightening.                                                     | NA  | NA      | Mechanical Straightening |

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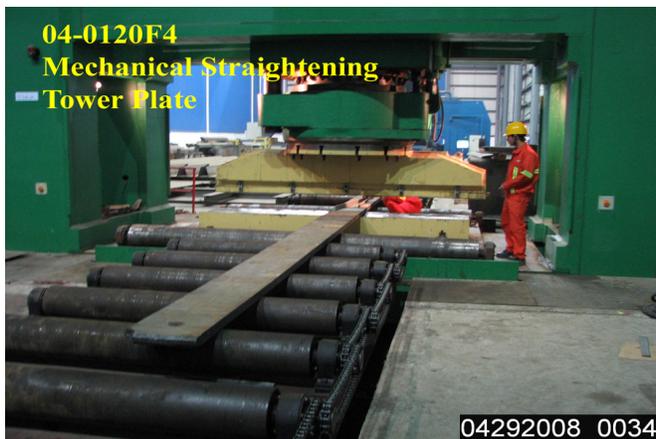
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- 3 Deck Panel NA NA QA-UT  
New OBG Shop, Outside Storage Yard: Caltrans QA Inspector performed an Ultrasonic Test (UT) inspection of the partial joint penetration (PJP) weld joining the closed u-rib to the deck panel. The deck panel assembly is identified as DP041-001 and weld 006. Caltrans QA Inspectors, Mr. Mike Hasler UT tested, Y-0 to 7480mm mark and Mr. Paul Dawson tested Y-7480 to 14960mm, UT weld coverage, 100 percent. Caltrans QA Inspectors recorded the results of the inspection and generated an ultrasonic test report. See Caltrans Ultrasonic Testing Report (TL-6027 Modified), dated April, 28, 2008 for additional information. The following digital picture illustrates QA-UT inspected deck panel.



- 4 PMT NA NA ZPMC VT & UT  
OBG Bay 1: Caltrans QA was notified by ZPMC QC that ZPMC would be performing ultrasonic testing of the production monitoring test (PMT), for closed rib assemblies DP111-002 and DP329-002. Caltrans QA witness ZPMC perform visual and ultrasonic inspection of the PMT. The ZPMC QC inspector performing the UT is identified as Ms. E Shuiqin. The following digital picture illustrates QC inspected PMT.

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## Summary of Conversations:

As identified within the contents of this report.

## 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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| <b>Inspected By:</b> | Hasler, Mike | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Cuellar, Robert | QA Reviewer |
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