

**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-002424**Date Inspected:** 20-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing, and 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:** See Below**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenghua Port Machinery Company (ZPMC) on Changxing Island, Shanghai, China to monitor the Quality Control (QC) functions during the fabrication of the Self Anchored Suspension (SAS) section of the San Francisco/Oakland Bay Bridge.

**OBG Preassembly Bay 7**

The QA Inspector observed ZPMC personnel cut slots into Floor Beam (FB) FB016-01, and fit and bolt diagonal tube steel braces onto FB003-012, and FB003-018.

The QA Inspector observed ZPMC personnel fit and tack weld plate stiffeners onto FB003-050, and FB003-055. The ZPMC welders used the Shielded Metal Arc Weld (SMAW) process. The ZPMC welders are Wang Changfa, ID #058102, and Liu Xie, ID #066236. The ZPMC Certified Welding Inspector is Hu Wei Qing.

The QA Inspector observed ZPMC QC personnel were present and adequately monitoring the work.

**OBG Preassembly Bay 8**

The QA Inspector observed ZPMC personnel back gouge the root on Diaphragm plate weld number ESD1-SA371-A/B-6A, at the 38-meter elevation.

The QA Inspector observed ZPMC personnel pre-heat but not weld Diaphragm plate weld number

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# WELDING INSPECTION REPORT

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SSD1-SA12-6A-1A (1B).

The QA Inspector observed ZPMC personnel heat straighten welded Diaphragm plate weld numbers WSD1-SA370-10A (10B), SSD1-SA334-A/B-2A (2B), SSD1-SA334-A/B-1A (1B), ESD1-SA309-11A (11B), and ESD1-SA309-12A (12B).

**Summary of Conversations:**

QA Inspector had no significant 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Stovall,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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