

**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-002520**Date Inspected:** 15-May-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

<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 Deck Panels	

**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue 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.

New OBG Bay 1: QA inspector performed ultrasonic testing (UT) verification before ZPMC Quality Control (QC) UT inspections on partial penetration joints of deck panels DP325-001 weld joint 1 and DP325-002 weld joint 8. QA UT inspected 15% of the total weld length of weld joints listed above. QA Inspector found lack of penetration indication that results in depth of penetration less than the minimum of 9.6 mm required on weld joint for deck panel DP325-001. Area inspected by QA UT Inspector for DP325-002 contained no areas of depth of penetration less than the required 9.6 mm. For details on UT inspections see modified TL-6027 UT Inspection reports dated 15 May, 2008.

Tower Bay 2: QA Inspector observed ZPMC QC UT inspection after repair on 45mm thick skin plate ESD1-233A/F 21B side B. QA Inspector noted that QC UT inspection and methods appear to meet the requirements of AWS D1.5, special provisions and contract documents. QC UT Inspectors Li Li Ming and Xue Hai Vong accepted weld repair and noted the inspection as acceptable on the skin plate.

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# WELDING INSPECTION REPORT

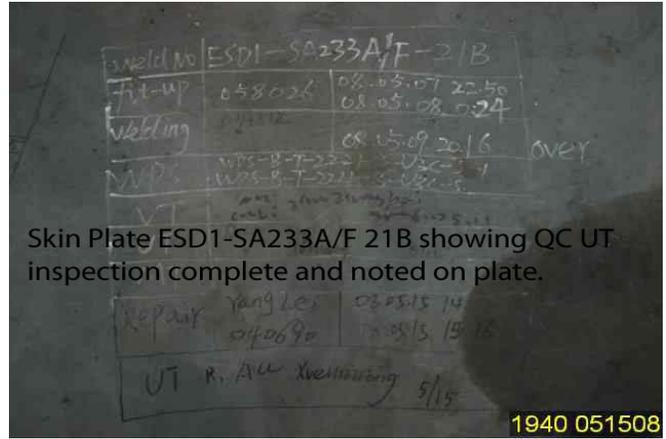
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ZPMC QC UT Inspector Li Li Ming UT inspecting repair area on skin plate ESD1-SA233A/F 21B

1940 051508



Skin Plate ESD1-SA233A/F 21B showing QC UT inspection complete and noted on plate.

1940 051508

## Summary of Conversations:

No significant conversations this day.

## 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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**Inspected By:** Prue,Erik Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert QA Reviewer