

**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-002790**Date Inspected:** 21-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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 weld trial**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge developing an spread sheet for comparing the welding parameters taken on the OBG weld trial welded on 10/18/07. The welding parameters were taken at the control panel and by welding heads. This data intended to calculate the deviations from the voltages, amparages, travel speed and heat input between all the welding parameters taken by Caltrans and ZPMC during the trial.

Tower Mock-up 89 M

In cursory visit to the shop the QA inspector observed that was preheating before welding the flange rings to the diaphragm SA-13. welding web corner connection plates P913-3 and 4, to SA-24s; cutting the ends from the skin panel D; fitting up skin panel C, subassembly MA23 (lower and upper panel); machining bevels from the piece mark mp534B.

**Summary of Conversations:**

The QA inspector did not have any relevant conversations on this date.

**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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# WELDING INSPECTION REPORT

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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

**Reviewed By:** Cuellar,Robert

QA Reviewer