

**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-003068**Date Inspected:** 07-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Zhi Jing**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:**

Bay 2

Milling Stiffener plates

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 2 it was noted that in the rear of this bay ZPMC was storing tube steel components for floor beam installations. Tower stiffener plates were at the horizontal milling machine for bevel preparations in conjunction to the CJP weldments.

Ultrasonic Testing

Bay 7

This QA inspector performed Ultrasonic Testing (UT) for QA verification (10%) of Complete Joint Penetration (CJP) weld joints. This QA inspector performed UT verification on floor beams after ZPMC had completed their inspection. The following are the weld numbers verified; FB003-035-104/105, FB003-055-104/105, FB003-051-104/105, FB003-028-104/105 and FB003-036-104/105. Also tested was SSD17-PP027-006. The weldments appeared to be in general compliance. A TL-6028 will be generated for these locations. This QA inspector spoke with ZPMC CWI Li Zhi Jing pertaining to SSD17-PP027-005 the diagonal tube steel brace that has been fit up to the floor beam. Face A is not accessible to perform UT due to fit up see digital photo below. ZPMC had not tested this weld at this time.

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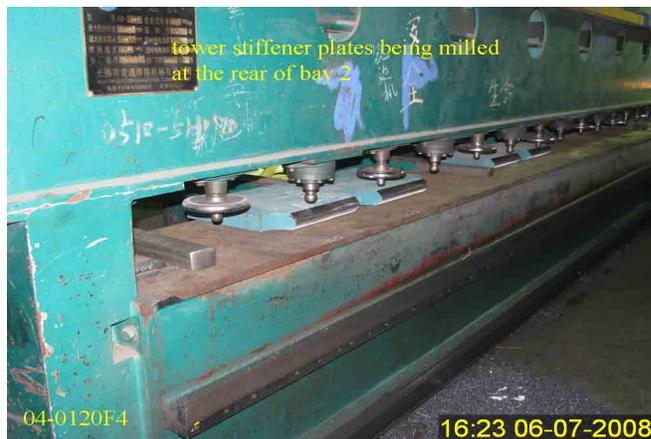
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above.

## 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:** Riley, Ken

Quality Assurance Inspector

**Reviewed By:** Carreon, Albert

QA Reviewer

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