

**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-003076**Date Inspected:** 17-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:** Wang Sai Fa**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 3--New Tower Building

The QA Inspector randomly observed ZPMC welding and QC personnel performing grinding of repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-five (35ea) deck panels are inside the shop. This QA inspector observed ZPMC MT personnel perform Magnetic Particle (MT) on deck panel DP0051-001 welds 001, 002, 005, 006, 009 and 010 for Critical Weld Repair (CWR) B-CWR-087 and DP030-002-001 for CWR B-CWR-109. The areas tested were acceptable as relayed to this QA inspector and witnessed herein. This QA inspector observed ZPMC performing repair work that was in-process on deck panels DP030-002 DP026-002 and DP042-001 by ZPMC. Certified Welding Inspector for ZPMC Wang Sai Fa was present at this location for the monitoring of the deck repairs and inspection.

UT-DP579-001 and DP277-001

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication and performed Ultrasonic Examination (UT) on the closed rib Partial Joint Penetration (PJP) weld joints. This QA inspector completed the UT verification and documentation for DP579-001 and DP277-001 there was several locations noted that was less than 9.6mm of Depth Of Penetration (DOP) these areas have been documented on UT report 6027 MOB for closed rib PJP welds. A TL-6028 will be generated for these locations.

**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

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## WELDING INSPECTION REPORT

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for your project.

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| <b>Inspected By:</b> | Riley, Ken | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Carreon, Albert | QA Reviewer |
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