

**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-003701**Date Inspected:** 01-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** An Qing Xiang**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**Summary of Items Observed:**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC in multiple stages of fabrication within tower shops 1 and 2 fitting skin plates and longitudinal stiffeners. It was also noted that ZPMC was welding with the Submerged Arc Welding (SAW) process for the Complete Joint Penetration (CJP) splice joints that included thicknesses in range from 90mm to 60mm. This QA Inspector noted ZPMC was in process of heat straightening various Tower Longitudinal Stiffener plates designated for the East Tower Skin Plate A and other various stiffener plates throughout the Shop. The heat straightening was accomplished by means of applied heat in limited applications as outlined in the applicable approved Heat Straightening Request (HSR). During this QA inspector's observations the total ZPMC personnel and QC working on the SFOBB project was recorded for tracking and distributed to the appropriate personnel.

**Summary of Conversations:**

No Conversations noted 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 Joshua Ishibashi 1-376-471-0411, who represents the Office of Structural Materials for your project.

**Inspected By:** Riley, Ken

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Carreon,Albert

QA Reviewer