

**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-000442**Date Inspected:** 14-Sep-2007**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:** Changxing Island**CWI Name:** Lu Jian Ping**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:** 77 E 114 A and E**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of the Caltrans Mock-up #77.00 and #114.00, for the San Francisco Oakland bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing Flux Core Arc Welding (FCAW) repair welding at Mock-up #77.00 Skin Plate E sub assembly MA1 longitudinal stiffener plate weld #2. ZPMC QA inspector Mr. Li Xiu Yong, repair welding was being performed in accordance with WPS-345-FCAW-1G (1F) repair 1 and the welder performing was Mr. Li Min Yang. The following digital picture illustrates the repair welding in progress. Removal of Lifting devices was in progress on Mock-up #114.00 Skin Plate E MP1021 to MA109.

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Mr. Cai Xin Xin perform magnetic particle testing (MT) and visual testing (VT). The testing was performed on Mock-up #114.00 Skin Plate A sub assembly MA107 longitudinal stiffener welds 1,2,3 and 4 Partial Joint Penetration tack welds. The testing appeared to be in conformance with AWS D1.5 2002 requirements. At the conclusion of testing ZPMC QC inspector Lu Jian Ping reported that the stiffener tack welds were found acceptable.

The Caltrans QA Inspector performed VT and MT examinations of the stiffener tack welds of #114.00 Skin A. Caltrans QA Inspector observed that the welds appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As identified within the contents of this report.

## 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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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary,David	QA Reviewer

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