

**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-000566**Date Inspected:** 02-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:** Tower Mock-up 114**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 and 114 meters elevations scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector reviewed the ZPMC's ultrasonic test (UT) reports for the skin B upper level. The skin B, weld joint # 8 had rejectable indications located at the same general location Y value 0. These indications were repaired three times on the same general area. After the third repair, ZPMC found a rejectable indication at the same general location. See sketch below shown with the approximate location of the rejectable indications reported on ZPMC's UT reports. The QA inspector had a conversation with the ZPMC QA inspector Fu Yu Hong. Mr. Fu relayed to the QA inspector that because the separation between rejectable indications ZPMC was not considering the repairs were located at the same location. The QA inspector had a conversation with the Caltrans Task Leader Jim Cochran. The QA inspector brought to Mr. Cochran attention that ZPMC performed three times UT repairs and found a four repair at the same general location. After reviewing the locations of the rejectable indication on the ZPMC's UT reports, Mr. Cochran and Senior Task Leader Dave McClary relayed to the QA inspector that the Contractor failed to notify before ZPMC proceed with the third repair and a non conformance report (NCR) needed to be issue to address this condition.

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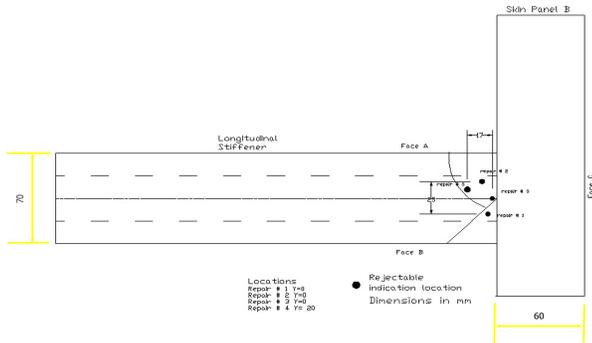
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# WELDING INSPECTION REPORT

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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:** Acuna, Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert

QA Reviewer