

**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-000659**Date Inspected:** 17-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:** Changxing Island

<b>CWI Name:</b>	Fu Guo Gau	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Closed Rib Trial	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the dimensional testing of Orthotropic Box Girder (OBG) Mock-up closed rib trial, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector witnessed ZPMC personnel performing dimensional measurements of tack weld length and spacing as well as fit-up gap of Orthotropic Box Girder (OBG). Dimensions were marked at adjacent locations on closed ribs. Measurements of the tack weld length appear to have been taken from the end to end including transition areas. The following pictures below shows the profile of tack weld after blending.

The fit-up gap was measured by ZPMC personnel. Caltrans QA performed random measurements of the fit-up. Measurements taken were less than the required .5 mm.

Comparison of measurements taken from ZPMC and Caltrans of the tack weld length appeared to be similar with minimal deviation. Tack welds were blended and transitioned for root pass welding. A total of 17 tack welds were noted on each weld.

Caltrans QA performed random dimensional measurements of closed rib to plate fit-up, tack weld length and spacing.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations 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 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>	Cuellar,Robert	QA Reviewer

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