

**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-004018**Date Inspected:** 12-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Jiang Jian Fei**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 skin assemblies, deck panels**Summary of Items Observed:**

## Tower shop - Bay 1

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: flame heat straightening of plates; electric preheat of stiffener to SSD1 – E lap assembly (approximately 2400mm square) in the tilted up position; FCAW-G automatic fill passes, with four welders on west gantry and two on east gantry, and FCAW-G manual of approximately 800mm at end of stiffener to SSD1 – skin C assembly; air-arc of stiffener to SSD1 – A; FCAW-G automatic fill pass, with one welder on gantry. Also present in this bay were ZPMC CWI Li Yang as well as ABF QC's Yang Yi Heng, C. K. Chan, Li Nan, and Zhang Qin Jian. Items observed appeared to comply with project specifications.

## Tower shop - Bay 2

QA Inspector randomly observed approximately 45 ZPMC workers performing the following: FCAW-G automatic fill passes, with four welders on gantry of stiffener to ESD1 – skin C assembly; ZPMC UT of stiffener to ESD1 – A assembly welds; preheat and tack of stiffener to ESD1 – C lap assembly welds. Also present in this bay were ZPMC CWI Jiang Jian Fei as well as ABF QC's Zhang Da Ming and Luo Lai Quan. Items observed appeared to comply with project specifications.

## Heavy Duty Machine Shop – Bay 3

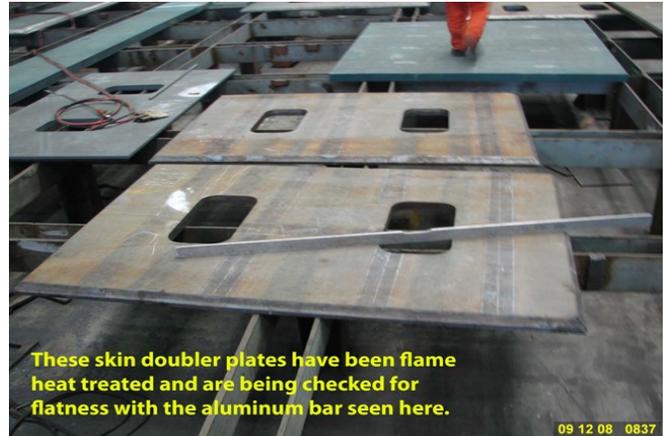
QA Inspector randomly observed 11 ZPMC workers performing the following: grinding of U-rib to deck panel welds on DP546-001, DP564-001, DP567-001, and DP601-001. There were 20 full size panels, 2 half size panels, and several unidentified deck plates in various stages of butt welding present in the bay. Also present in this bay were ABF QC Wang Zhong Yuan. Items observed appeared to comply with project specification.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant conversations this date.

## 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, 136-6471-0411, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George Quality Assurance Inspector

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**Reviewed By:** Carreon, Albert QA Reviewer