

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-004023**Date Inspected:** 19-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Yan Fe, Zhu Zhong Hai**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 55 ZPMC workers performing the following: flame heat straightening of plates; oxy-fuel cutting of bevels; grinding of cover pass on stiffener to SSD1-skin B assembly; FCAW-G of fill pass on stiffener 4B to SSD1-skin B lap assembly; oxy-fuel removal and grinding of run-off tabs on stiffeners to SSD1-skin E lap assembly; back-gouging of SSD1-SA61A/G-5B (A). Also present in this bay were ABF QC's Yang Yi Heng and Jiang Zi Wen. Items observed appeared to comply with project specifications.

## Tower shop - Bay 2

QA Inspector randomly observed approximately 85 ZPMC workers performing the following: FCAW-G manual with two welders and automatic with four welders southwest gantry on stiffener to ESD1-skin C assembly; SMAW and FCAW-G of root and fill passes of doubler plates to ESD1-skin A assembly; grinding of cover pass of stiffeners to ESD1-E assembly; bevel cutting of plates; SAW of skin plate butt welds. Also present in this bay were ZPMC CWI's Guo Yan Fei and Zhu Zhong Hai as well as ABF QC Zhang Da Ming and C.K. Chan. Items observed appeared to comply with project specifications.

## Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed three ZPMC workers in this bay. There were 17 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. A ZPMC UT operator was performing UT on unidentified deck plate butt welds. Items observed appeared to comply with project specifications.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## 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.

---

<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

---