

**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-004065**Date Inspected:** 07-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Qin Jian**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:** OBG & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate A Tower Shop	NA	NA	QA/VT

Heavy Duty, Bay 1: Caltrans QA inspector performed visual test (VT) inspection. The subassembly is identified as Segment 3, Skin Plate "A", longitudinal stiffener, partial joint penetration (PJP) cover pass welds joining skin plate "A". The longitudinal stiffeners are identified as part number p327 (3qty), p322 (qty1), p39 (3qty) and p38 (qty1). Caltrans QA inspector identified several locations that required rework. These locations were marked up for weld grinding pick-ups. The ABF Quality Control inspector, Mr. Zhang Qin Jian was present during Caltrans QA inspection and confirmed the findings. Mr. Zhang Qin Jian directed ZPMC to correct the locations that were identified by Caltrans QA inspector for rework. The inspection coverage started at elevation mark 38M Top Diaphragm Plate location to elevation mark 47.6 M mark and continued to longitudinal stiffener termination. At the completion of the VT inspection, Caltrans QA inspector informed Mr. Zhang Qin Jian that the welds appeared to be in conformance with the project specifications. See Caltrans nondestructive Tower Tracking Log, on file in the OSM field office for additional information.

2	Deck Panel OBG	NA	NA	QAUT
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Assembly Building: Caltrans Quality Assurance (QA) inspector performed conventional ultrasonic test (UT), gate to

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gate inspection of tack welds joining u-rib to deck plate. The deck panel is identified as DP137-001 with five u-ribs, ten welds. Each weld consisted of eighteen tack welds per weld. The UT inspection performed by the Caltrans QA inspector was preliminary UT inspection prior to using the phase ray system to verify indications found by the conventional ultrasonic test. Caltrans QA inspector identified two indications at weld 001; weld 002 (0 indications); weld 003 (2 indications); weld 004 (3 indications); weld 005 (13-indications); weld 006 (3 indications); weld 007 (6 indications); weld 008 (13 indications); weld 009 (6 indications) and weld 010 (7 indications). Caltrans QA inspector recorded the Y-locations for indications found in the weld during the UT inspection. See Caltrans U-rib to Deck Plate – Tack Weld Assessment Record, dated 10-07-2008 for additional information.

### 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 Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer
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