

**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-004171**Date Inspected:** 14-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

The Quality Assurance Inspector observed ZPMC continuing to repair cracks in the tack weld areas of numerous deck panels. Two ABF representatives were present tracking the locations and witnessing the repairs. ZPMC was performing the weld repairs to Deck Panels DP-051-001, DP-050-001, DP-074-001, DP-075-001, DP-053-001 and DP-054-001. The Quality Assurance Inspector tracked the locations and the status of the repairs and recorded the data in an onsite log for future review. In addition the Quality Assurance Inspector witnessed ZPMC in the process of excavating a number of deck panels identified as DP-55-001, DP-056-001, DP-044-001, and DP-042-001. The Quality Assurance Inspector performed magnetic particle verification to the repairs after the tacks were excavated; the root pass was deposited and ground. No relevant indications were observed.

For informational purposes only ZPMC performed magnetic particle testing to the initial excavation. The Quality Assurance Inspector observed on numerous excavations a linear indication indicative of a crack at the exact location where the Quality Assurance Ultrasonic technicians marked the area as cracked below is digital photograph illustrating one of the indications.

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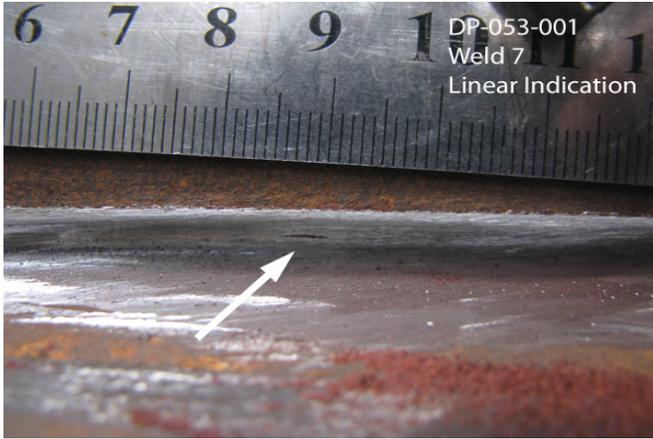
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As stated in the contents of the above 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(707) 552 7715, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

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