

**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-004175**Date Inspected:** 22-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.

**Tower Strut Partial Mock-up**

The Quality Assurance Inspector observed ZPMC in the process of performing in process welding of the 89M Strut Partial Mock-up. ZPMC was utilizing the shielded metal arc welding process to deposit the root pass of the flanges and web complete joint penetration splices. The Quality Assurance Inspector informed an ABF Representative of a small amount of rust on the bevel faces of the welds. The ABF representative relayed he would have ZPMC remove the rust prior to any further welding. Below is a digital photograph illustrating the rust.

**89M Tower Mock-up Assembly**

The Quality Assurance Inspector observed ZPMC welder Li Meng Qian, performing in process welding of a bracket lug to diaphragm plate connection. Quality Control Inspector Ye Yong Jun was monitoring the welder. The welder was using the flux cored arc welding process to produce the fillet weld in the vertical position. The Quality Assurance Inspector measured the welding parameters at Mr. Qian's station and found the parameters to meet requirements of welding procedure specification WPS-B-T-2133. The Quality Assurance Inspector witnessed Quality Control measuring the interpass temperature using a calibrated infrared temperature gun.

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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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