

**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-004244**Date Inspected:** 19-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Fabrication	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Bay 4

The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of the following OBG component welds in support of the yellow "In Process" tagging:

SP463-001-001 through -010; In process tag 1096  
SP397-001-001 through -016, -032 through -043; In process tag 0323  
BP120-001-007 through 018; In process tag 1093  
BP035-001-001 through -012; In process tag 1199

ZPMC Inspection personnel had previously visually & MT inspected/accepted these welds. Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

Heavy Bay 1

The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of the following tower

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# WELDING INSPECTION REPORT

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component welds:

NSA1-SA178C/D-13, Lift 2 Tower Skin B

SSD1-SA61A/G-6, -7 & -9, Lift 2 Tower Skin E

SSD1-SA61G/G-1 Lift, 2 Tower Skin E

ZPMC Inspection personnel had previously visually & MT inspected/accepted these welds. Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

**Summary of Conversations:**

See above.

**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 13816942685, who represents the Office of Structural Materials for your project.

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

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