

**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-004246**Date Inspected:** 21-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:

**OBG Bay 3**

ZPMC notification of witness inspection document #01250 dated 10-21-2008 states that ZPMC QC inspection personnel will be conducting ultrasonic inspections of OBG side plate weld SP315-001-055. The QA Inspector asked ABF QC CWI Mr. Li Jang #07120711 for assistance in locating this weld. Mr. Li Jang informed the QA Inspector that the notification of witness document is incorrect and that weld SP315-001-55 is incorrect and that the correct number is SP315-001-064. ABF representative concurred that the incorrect number is listed on the notification of witness document and that the correct weld number is SP315-001-064.

The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of OBG side plate weld SP315-001-064. ZPMC Inspection personnel had previously visually & UT inspected and accepted these welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

**OBG Bay 7**

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## WELDING INSPECTION REPORT

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The QA Inspector performed random AWS D1.5 ultrasonic inspections of the following OBG floor beam complete joint penetration welds:

FB012-007-045

FB013-019-045

ZPMC Inspection personnel had previously performed UT inspections and accepted these welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of the following OBG floor beam welds:

FB011-014, -010, -013, 014, 022, 023, 027, 028, 029, 030, 031, 032, 037, 038, 039, 040, and 044.

FB016-004, -010, -013, 014, 022, 023, 027, 028, 029, 030, 031, 032, 037, 038, 039, 040, and 044.

The QA Inspector observed weld FB016-004-023 had overlap at the bottom toe of the weld. The QA Inspector informed ABF CWI Lin Rei Wei of these conditions. ZPMC then assigned a person to blend the area of the weld where the overlap was located. Following the rework of the weld the QA Inspector determined the areas that were VT and MT inspected appear to comply with project specifications.

ZPMC Inspection personnel had previously performed VT and MT inspections and accepted these welds. 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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