

**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-004259**Date Inspected:** 27-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:**

Heavy Bay #1

ZPMC notification of witness inspection document #01294 dated 10-27-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of tower component welds in heavy bay #1 on October 26. See below for the weld numbers and the status of the welds.

SSD1-SA61 AG-2A/B, 9A/B and 17A/B: These weld has not been marked as having been ultrasonically inspected by ZPMC QC.

NSD1-SA11AF -1A/B: ZPMC has marked this weld as being UT accepted and the QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of this weld. Items observed appear to comply with project specifications.

Heavy Bay #2

ZPMC notification of witness inspection document #01288 dated 10-26-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of tower component welds in heavy bay #1 on October 26. See below for the weld numbers and the status of the welds.

ESD1-SA300E/F-8A/B R1: This weld has been marked as being ultrasonically rejected by ZPMC QC.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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ESD1-SA300E/F-12A/B R1: The QA Inspector observed that on October 26, 2008 ZPMC marked this weld as being UT acceptable. Today the QA Inspector observed ZPMC is performing heat straightening of this plate adjacent to the weld. The QA Inspector informed ZPMC QC representative Mr. Testino that the heat straightening has been performed near the weld heat affected zone and the QA Inspector asked Mr. Testino if ZPMC is going to conduct an additional UT inspection of this weld due to this heating. Mr. Testino said he will have the weld UT inspected this evening.

ZPMC notification of witness inspection document #01293 dated 10-27-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of tower component welds in heavy bay #2 today. See below for the weld numbers and the status of the welds.

ESD1-SA384A/D-35A/B and 32A/B: This weld has not been marked as being visually or ultrasonically accepted.

ZPMC notification of witness inspection document #01292 dated 10-27-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of tower component welds in heavy bay #2 today. See below for the weld numbers and the status of the welds.

ESD1-SA218-1A/B through -4A/B: ZPMC has marked these welds as having ultrasonic rejections.

ESD1-SA99-1A/B through -4A/B: ZPMC has a person using a grinder to prepare the base material for ultrasonic inspections. ZPMC has not UT'd these welds.

WSD1-SA80A/E-43A/B: ZPMC has marked these welds as being visually rejected and there is no markings to indicate these welds are UT accepted by QC personnel.

WSD1-SA49A/E-15A/B: ZPMC has marked this weld as being UT accepted and the QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of this weld. Items observed appear to comply with project specifications.

WSD1-SA279A/E-15A/B: ZPMC has marked this weld as being UT accepted and the QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of this weld. Items observed appear to comply with project specifications.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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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