

**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-004348**Date Inspected:** 15-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**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>	Zhang Huang	<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>	Tower	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the fabrication and general activities associated with Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**Heavy Machinery Bay 1:**

QA performed MT verification of ZPMC tested and accepted Skin E Doubler plate welds of the south tower welds SSD1-SA173 B/K 1, 4/ A/K 9, 10, 11, 12 and Tower manhole ID and OD weld SSD1-SA16 A/G 16 SSD1-SA16 E/G 38. As per a conversation with ABF representative Mike Williams South Tower Skin Plate E was not scheduled for green tagging due to an RFI concerning the fillet weld size of the Inner fillet weld on Doubler Plates. Mr. Williams stated that these areas would be accessible after installation. Please see TL-6028, generated on this date for additional information.

QA performed MT verification of ZPMC tested and accepted Skin E longitudinal stiffener welds of the south tower welds SSD1-SA16 F/G welds 32, 33, 38, 39, 44, 45, 56 and 57. Gouge areas up to 4 mm were noted on the stiffener welds on diaphragm side at weld ends. Areas were repaired ZPMC welder Mr. Bai Weiming performing Flux Cored Arc Welding in the horizontal position. Welding appeared to be in conformance with WPS-345-FCAW 2G (2F). After welding was completed the weld repair was ground flush and retested by ZPMC and The Caltrans QA. No relevant indications were noted after repair. Please see TL-6028, generated on this date for additional information.

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# WELDING INSPECTION REPORT

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QA witnessed ZPMC performing MT of South Tower Skin C longitudinal stiffener welds. MT was not completed as of 2115.

Heavy Machinery Bay 2:

QA performed UT verification of ZPMC tested and accepted Tower Skin Plate welds EDS1-SA388 A/D weld 2 and 4. Testing was performed from the B side of weld ZPMC accepted welds form the A face. Please see TL-6027, generated on this date for additional information.

No other activities observed.

**Summary of Conversations:**

Only general conversations between Caltrans QA and QC occurred this date.

**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 Joshaua Ishibashi, 137 6471 0411, who represents the Office of Structural Materials for your project.

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

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