

**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-004353**Date Inspected:** 02-Oct-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.

**Deck Panel Tack Weld Demonstration**

The Quality Assurance Inspector performed a review of macro etch samples representing the tack weld demonstration of closed rib partial joint penetration welds. Twenty samples were originally marked to be sampled when the demonstration was welded. All the samples contained greater than 80 percent penetration and no anomalies were observed. Magnetic Particle verification was performed and the results coincided with the visual. A spreadsheet was created and placed on the internal server for further information. The Samples were digitally photographed and placed on the internal server for future review.

**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 Peter Dautermann 137.6471.0411, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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**Inspected By:** Bertlesman, Greg

Quality Assurance Inspector

**Reviewed By:** Wright, Mark

QA Reviewer