

**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-004467**Date Inspected:** 14-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Zhang Huang, An Qing Xiang	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b> <b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b> <b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b> <b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b> <b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b> <b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	tower skin assemblies	

**Summary of Items Observed:**

## Heavy Bay 1:

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed approximately 60 ZPMC workers performing the following: SAW of skin plate butt welds; FCAW-G of upper connection plates to stiffeners on SSD1-C skin assembly; fitting and SMAW tacking of stiffeners to SSD1-A-lift 2 skin assembly; SMAW repair of indications in the doubler plate to skin welds on SSD1-E skin assembly.

ZPMC QC Ken Zhang informed QA Inspector that SSD1-skin C stiffener to skin plate welds are ready for inspections and green tagging. QA Inspector performed random visual inspections of SSD1-Skin C stiffener to skin plate welds on both sides of stiffener 1 and the adjacent weld on one side only of stiffener 2. QA Inspector observed no apparent indications.

Also present in this bay were ZPMC CAWI Zhang Huang as well as ABF QC's Yang Ye Heng and Zhang Qin Jian. Items observed appeared to comply with project specifications.

## Heavy Bay 2:

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: fitting, flame preheating and SMAW overhead tacking of skin plate B to skin plate C on the SSD1 tower assembly; SAW of skin plate butt welds; flame cutting of bevels on skin plates.

Also present in this bay were ZPMC CWI An Qing Xiang as well as ABF QC Luo Lai Quan. Items observed appeared to comply with project specifications.

**Summary of Conversations:**

As noted in Summary.

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# WELDING INSPECTION REPORT

( *Continued Page 2 of 2* )

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## 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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

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

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