

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-004520**Date Inspected:** 03-Nov-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:

**Heavy Bay 3**

This QA Inspector and QA Inspector B25 performed final visual inspections of the stiffener welds of the deck panels listed below. These deck panels that are located in heavy bay #3 have both closed rib and straight ribs. The QA Inspectors observed ZPMC and ABF representatives had completed visual inspections of these welds and they had identified the welds are acceptable on the yellow inspection status tag that is attached to each of the deck panels. The QA Inspectors identified a few areas of welding flux and weld spatter that had not been completely removed. Following rework, items observed appear to comply with project specifications. The QA Inspectors documented the final visual inspections on the yellow inspection status tags that are attached to the deck panels.

DP585-002 welds 11 to 18 and 23 to 30  
DP575-001 welds 11 to 18 and 27 to 34  
DP590-001 welds 13 to 22 and 33 to 42  
DP585-001 welds 11 to 18 and 23 to 30  
DP545-002 welds 11 to 18 and 23 to 30  
DP565-001 welds 18 to 23 and 9 to 14

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

## OBG Bay #4

ZPMC notification of witness inspection document #01338 dated 11-03-2008 states that ZPMC inspection personnel will be conducting green tag magnetic particle (MT) inspections of side plate welds today. See below for the weld numbers and the status of the welds that were observed by this QA Inspector today:

SP577-001-092 to 103 and 30 to 41: ZPMC has marked various welds on this side plate as being MT accepted. The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of approximately 10% length of the welds where QC had also completed MT inspections of a percentage of the total welds. Items observed by this QA Inspector appear to comply with project specifications. See the TL6028 Magnetic Particle Test Report for additional information.

## OBG Bay #8

ZPMC notification of witness inspection document #01339 dated 11-03-2008 states that ZPMC inspection personnel will be conducting green tag magnetic particle (MT) inspections of floor beam welds today. The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of approximately 80% length of the welds and items observed appear to comply with project specifications. See the list of the welds that were inspected by this Inspector below and the TL6028 Magnetic Particle Test Report for additional information. The Notification of Witness Inspection document indicates these floor beam assemblies have a status of "Tagging In Process" but none of these floor beam assemblies have a yellow or a green tag attached to them.

FB006-107-012, FB006-108-006, FB006-109-017, FB006-110-011, FB006-111-011, FB006-112-015, FB006-113-011, FB006-114-014, FB006-115-005, FB006-116-005, FB006-117-007, FB006-119-016, FB006-120-010, FB006-121-010, FB006-122-012, FB006-123-019, FB006-125-010, FB006-126-014, FB006-127-014, FB006-128-007, FB006-129-010 and FB006-130-007.

### 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.

---

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

---