

**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-004849**Date Inspected:** 03-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Zhong Jian Di  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform random inspections Orthotropic Box Girder components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**Sub assembly Bay 4:**

The Caltrans QA performed Magnetic Particle Testing (MT) verification and visual inspection of ZPMC tested and accepted SP436A stiffener fillet welds SP436-001-001 through 010. After MT and VT verification of stiffener welds Caltrans QA signed ABF documentation for green tagging along with ZPMC and ABF QC. No relevant indications were noted during testing please see MT report TL-6028, generated on this date for further information.

**Sub Assembly Bay 8:**

The Caltrans QA performed Magnetic Particle Testing (MT) verification and visual inspection of ZPMC tested and accepted 38 meter west tower double diaphragm welds (SA372 to SA370). No relevant indications were noted during testing please see MT report TL-6028, generated on this date for further information.

The Caltrans QA performed Magnetic Particle Testing (MT) verification and visual inspection of ZPMC tested and accepted 47.6 meter west tower double diaphragm welds (SA32 to SA226). No relevant indications were noted during testing please see MT report TL-6028, generated on this date for further information.

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# WELDING INSPECTION REPORT

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**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 Peter Dautermann 150 0219 9593, 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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