

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004876**Date Inspected:** 04-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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:** Tower & OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate A Tower	NA	NA	QA-VT
	Heavy Shop 2: ZPMC quality control inspector, Mr. Fu Yu hong met with Caltrans QA inspector and requested QA visual inspection, green tag for skin plate in Heavy Shop 2. Mr. Fu informed Caltrans QA inspector that the subassembly has been inspected by ZPMC and American Bridge/Fluor inspectors and accepted for conformance. Mr. Fu assigned ZPMC QC inspector, Mr. An Qing Xiang to go with Caltrans QA inspector during the visual inspection of the skin plate. Caltrans QA inspector performed visual inspection of Lift 2 East Tower Skin Plate "A", longitudinal stiffener weld joining skin plate. At completion of the QA-VT inspection, QA had observed 29 locations for weld pick-ups. ZPMC QC inspector, An Qing Xiang confirmed the findings and stated that weld pick-ups would be fixed by ZPMC and the subassembly would be present to the day shift for (re)inspection.			
2	OBG Floor Subassembly Beam OBG	NA	NA	QA-MT
	Bay 7: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001551 (tagging in progress). The subassemblies are identified as OBG floor beam; FB027-005 and FB028-005; welds FB027-005-023, 024, 058, 074, 075, 073, 036, 037, 053, 052, 065, 146 and FB028-005-149, 146, 109, 110, 104, 105, 092, 084, 085, 089, 090, 125 cover pass weld. Caltrans QA inspector			

