

**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-004944**Date Inspected:** 25-Nov-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:** Tower**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.

**Tower Strut Partial Mock-up Macro Samples**

The Quality Assurance Inspector evaluated macro-etch samples of the tower strut partial mock-up. There were a total of six fillet weld samples that ABF and ZPMC accepted. The Quality Assurance Inspector observed what appeared to be a crack in the root of sample 5F4. ZPMC disagreed with the Quality Assurance Inspectors findings and requested to re-machine and re-etch the sample. After it was re-examined ZPMC still insisted it was acceptable and ABF Representative Mike Williams stated it appeared to be a fusion type anomaly and was rejecting it. The Quality Assurance Inspector photographed the samples and forwarded them to Assistant Structures Representative Josh Ishibashi. Below is a digital photograph of sample 5F4.

**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 Josh Ishibashi 1.376.647.10411, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Bertlesman, Greg	Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright, Mark	QA Reviewer
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