

**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-005002**Date Inspected:** 11-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wan Lu**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:** OBG & Tower**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 E	NA	NA	QA Green Tag Inspection

Tower

Heavy Shop 2: During shift change, Caltrans QA inspector Mr. Ricardo Medina stated that he visually inspected Lift 2 Skin Plate E and marked up the skin plate for weld pick-ups. Mr. Medina stated that ZPMC was still grinding on the skin plate weld pick-ups at the end of his shift. Shortly after this inspector's arrival at ZPMC, this Caltrans QA inspector met with ZPMC QC inspector, Mr. Wan Lu (Testino) and inquire about the status of skin plate E. Mr. Lu was not sure about the status. However, Mr. Testino and this inspector went to heavy shop 2 and located the skin plate E. ZPMC at this time was not grinding on the skin plate and it appeared that the locations that were marked for weld pick-ups were completed. Mr. Lu stated it's ready for Caltrans (re) inspection. However, after a closer look at the skin plate, this inspector observed that weld pick-ups were not performed at locations where lifting aid came in close contact to the area of interest, which was marked up for grinding. This inspector informed Mr. Lu of these weld locations. Mr. Lu stated that a hand-held grinder is too large to get in there to grind. This inspector informed Mr. Lu that, until these locations are corrected by ZPMC, Caltrans visual inspection on this skin plate can't be completed. Mr. Lu agreed and stated ZPMC's day-shift grinding crew would complete this grinding, only after they get the right kind of grinding tool for the job.

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## WELDING INSPECTION REPORT

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2	OBG Bottom Plate Subassemblies OBG	NA	NA	QA-MT
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Bay 4: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001624, item #1. The subassembly is identified as OBG bottom plate; welds BP070-001-001, 002, 003, 004, 005, 006, 007, 008, 009, 010, 011 and 012. The cover pass welds appeared to be QC-MT inspected and accepted by ZPMC. Caltrans QA-MT coverage was approximately 10%. The cover pass welds were found to be in compliance with the project specification. See Caltrans Magnetic Test Report (TL-6028) dated, 12-11-2008 for additional information

### Summary of Conversations:

As identified within the contents of this 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 Peter Dautermann 150-0219-9593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer
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