

**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-005399**Date Inspected:** 06-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 Fabrication**Summary of Items Observed:**

CWI: Mr. Sun Wei

On this date CALTRANS OSM 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:

**OBG Bay 3**

This QA Inspector performed random ultrasonic (UT) inspections of OBG floor beam welds FB028-007-078, FB028-007-079, FB040-003-078. These welds are listed on ZPMC Notification of Witness Inspection document 001930. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

**OBG Bay 12**

This QA Inspector performed random ultrasonic (UT) inspections of OBG deck plate welds DP615-001-011, DP615-001-251, DP615-001-13, DP615-001-252, DP615-001-15, DP615-001-253. These welds are listed on ZPMC Notification of Witness Inspection document 001933 which states the area of inspection is limited to the 15000 mm adjacent to the closed ribs for welds 11, 13 and 15. The QA Inspector observed the welds that were

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ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

This QA Inspector observed ZPMC welder Mr. Song Yun Shu, stencil 059421 is using welding procedure specification WPS-345-FCAW-1G(1F)-Repair-1 to weld closed ribs to OBG deck plate weld DP540-001-013R2. Prior to welding the QA Inspector observed the base material had previously been preheated using an electrical heater. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

## OBG Bay 2

This QA Inspector performed random ultrasonic (UT) inspections of OBG weld SEG-004A-006. This butt weld joins baseplate BP312A to BP310A. This weld is listed on ZPMC Notification of Witness Inspection document 001925. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appears to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report and the photograph below.



### 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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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

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