

**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-006291**Date Inspected:** 09-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 Inspector: NA

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 19**

This QA Inspector performed random magnetic particle (MT) inspections of OBG Cross Beam welds CB205J-1-002-146, CB205J-1-002-147, CB205J-002-453 and CB205J-002-454. These welds had previously been MT inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were MT inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6028 Magnetic Particle Test Report.

This QA Inspector performed random magnetic particle (MT) inspections of OBG Bottom Plate welds BP026-005-004, BP026-005-014 and BP026-005-044. These welds had previously been MT inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were MT inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6028 Magnetic Particle Test Report.

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This QA Inspector performed random ultrasonic inspections of OBG Floor Beam welds FB210-001-37, FB210-002-37, FB210-1-001-37 and FB210-1-002-37. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. 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 13 and Bay 14

ZPMC QC representative Mr. Fu Yuhong presented this QA Inspector, Mr. Paul Dawson, with "Inspection Notification Document #02581 which states twenty one OBG Deck Plates are ready for green tagging in OBG bay #13 and bay #14. This QA Inspector accompanied Mr. Fu Yuhong and ABF representative Mr. Primo Chan to OBG bay #13 and #14. This QA Inspector performed random observations of these twenty one Deck Plates and this QA Inspector concurred with issuance of green tag releases of the OBG Deck Plates. The QA Inspector wrote lot number B254 on each of the green tag documents, below where Mr. Primo Chan and Mr. Fu Yuhong have signed these sheets. Below is a list of the OBG Deck Plate welds and the applicable green tag numbers:

DP411-001~010 Green tag 5884  
DP331-001~008 Green tag 2821  
DP258-001~010 Green tag 2822  
DP139-001~010 Green tag 2823  
DP224-001~010 Green tag 2824  
DP117-001~008 Green tag 2825  
DP252-001~010 Green tag 2826  
DP276-001~006 Green tag 2827  
DP274-001~006 Green tag 2828  
DP112-001~008 Green tag 2829  
DP111-001~008 Green tag 2830  
DP246-001~010 Green tag 2831  
DP225-001~010 Green tag 2832  
DP280-001~006 Green tag 2833  
DP115-001~008 Green tag 2834  
DP118-001~008 Green tag 2835  
DP143-001~010 Green tag 2836  
DP145-001~010 Green tag 2837  
DP140-001~010 Green tag 2838  
DP086-001~006 Green tag 2839  
DP221-001~010 Green tag 2840

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## 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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