

**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-006294**Date Inspected:** 15-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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:** Tower Fabrication**Summary of Items Observed:**

CWI Inspectors: 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:

Prior to Caltrans QA Inspectors' concurring with issuance of OBG deck plate closed rib green tag releases a review of the ultrasonic inspection database is performed to verify all closed rib tack weld repair locations have been ultrasonically accepted. Today this QA Inspector, Mr. Paul Dawson, performed data entry of ultrasonic inspection information from the field generated Ultrasonic inspection data sheets onto the common drive computer database for the following OBG deck panels: DP119-002, DP497-001, DP281-001, DP227-001, DP146-001, DP335-002, DP283-001, DP538-001, DP336-001 and DP092-001.

**OBG Bay 5**

This QA Inspector, Mr. Paul Dawson, performed random ultrasonic inspections of OBG cross beam welds B202C-006-001, B202C-006-002, B202C-006-003 and B202C-006-004. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed weld B202C-006-003 appears to have a class "A" (rejectable) indication located at approximately 3900 mm from the end of the weld. The QA Inspector informed ZPMC QC representative Mr. Lay Tau who informed this QA

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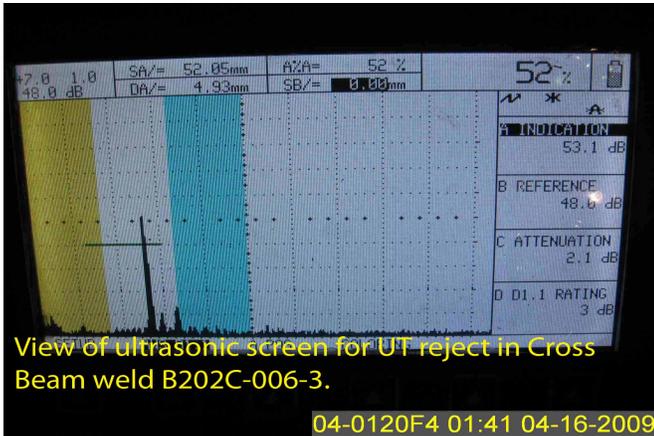
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Inspector that due to the late hour there are not ZPMC ultrasonic inspection personnel presently working at this time and he will have dayshift ultrasonic inspection personnel ultrasonically inspect this weld again. The other three welds that were 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. Note: Dayshift Caltrans Quality Assurance Inspector Mr. Albert Carreon informed this QA Inspector that during the day shift, ZPMC Quality Control ultrasonic Inspectors confirmed that weld B202C-006-003 has class "A" (rejectable) indications and that ZPMC has performed weld repairs of the rejected areas. See the photographs below for additional information.



### 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
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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