

**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-011322**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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**Summary of Items Observed:**

CWI Inspector: N/A

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. This QA Inspector observed the following:

**OBG Assembly Yard**

ZPMC informed dayshift QA personnel that ABF Inspectors have completed ultrasonic (UT) inspections of OBG deck plates complete joint penetration butt welds between segments 5AW and 5BW and they are ready for QA ultrasonic inspections. This QA Inspector performed random ultrasonic for detection of longitudinal and planar transverse indications utilizing scanning pattern A, B, C and D (AWS D1.5 Fig 6.7) inspections of approximately 25 percent of OBG segment 5AW weld OBW5-003 and 50 percent length of welds OBW5-002, OBW5-004. Caltrans QA Inspector Mr. Daniel Barrentine also performed approximately 25 percent of weld OBW5A-04. Items observed on this date appeared to generally comply with applicable contract documents.

ZPMC informed dayshift QA personnel that ABF Inspectors have completed ultrasonic (UT) inspections of the bikepath side plates complete joint penetration butt welds between segments 6AE and 6BE and they are ready for QA ultrasonic inspections. This QA Inspector performed random ultrasonic for detection of longitudinal and planar transverse indications utilizing scanning pattern A, B, C and D (AWS D1.5 Fig 6.7) inspections of weld

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# WELDING INSPECTION REPORT

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OBE6B-003 between locations Y=0 (bottom) and Y=4030mm Caltrans QA Inspector B270 performed ultrasonic inspections of the remainder of this weld. Items observed on this date appeared to generally comply with applicable contract documents.

**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>	Carreon,Albert	QA Reviewer

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