

**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-013500**Date Inspected:** 14-Apr-2010**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: 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. This QA Inspector observed the following:

During MT inspections in OBG segment 9DE this QA Inspector observed ZPMC welder Mr. Wu Hai Jun, stencil 201087 used shielded metal arc process to make tack weld CA066-042. This tack welding took place in OBG segment 9DE between corner assembly CA66A between panel points PP81 and P81.5. No QC or CWI Inspectors were inside or near this OBG segment while this QA Inspector performed this observation of the welding activity. This QA Inspector observed that ZPMC personnel used a torch to preheat the base material prior to welding. Shortly after these tack welds were made (less than 30 minutes time) the workers removed their equipment and left the segment. Items observed on this date appeared to generally comply with applicable contract documents, see the photograph for additional information.

OBG Segment 9DE located in yard near the front of Bay 16

Earlier in the day ZPMC presented QA personnel with "Notification of Witness Inspection" document #005523 item 2 that states ZPMC is requesting Caltrans to perform magnetic particle and ultrasonic inspections of OBG segment 9CE as listed on Tag #1 through Tag #7. This QA Inspector performed random magnetic particle (MT)

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# WELDING INSPECTION REPORT

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inspections of the welds that are listed below and these welds appear to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

Tag 3:

Seg056B-031, 032, 033, 034

Seg056C-031, 032, 033, 034

Tag 4:

SSD17-42, 44, 46, 48, 50

SSD17-14, 16, 18, 20, 68, 70, 72, 74, 75

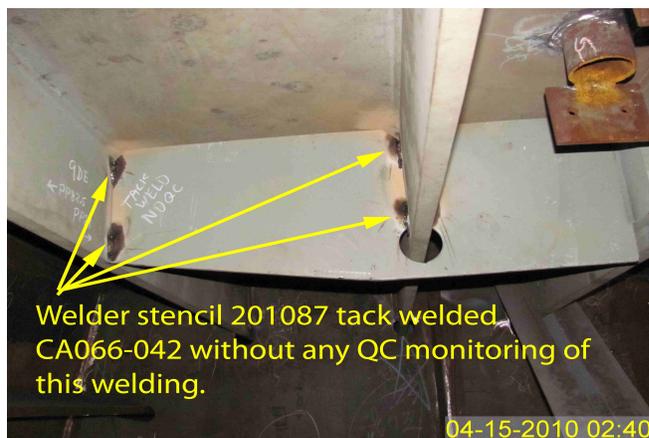
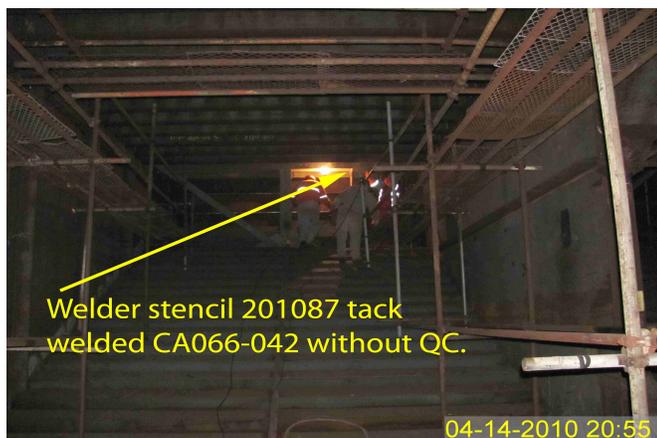
SSD24-107,108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122

SSD18-43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56

Tag 6

CSD2-PP81.5-46, 50, 52, 54, 58, 60, 62, 64, 155, 156, 157, 158, 159, 160, 161, 162

CSD4-PP81-73, 83, 85, 86, 87, 130, 132, 137, 24, 26, 28, 30, 51, 53, 55



## 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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**Inspected By:** Dawson,Paul

Quality Assurance Inspector

**Reviewed By:** Carreon,Albert

QA Reviewer

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