

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022734**Date Inspected:** 20-Apr-2011**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

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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:

**OBG Trial Assembly**

ABF issued ultrasonic inspection report number UT-13W-022R1 stating that OBG segment 13BW weld SEG3014-003 joining deck plate DP3136A to DP3135A and report number UT-13W-019R1 stating that OBG segment 13BW weld SEG3014-009 joining deck plate DP3130A to DP3129A have both been ultrasonically inspected and accepted using scanning patterns A, B, C, E on the exterior and scanning pattern D on the interior of the welds. This QA Inspector performed random visual and ultrasonic inspections of the welds listed above using scanning patterns A, B, C, E on the exterior and scanning pattern D on the interior of the welds and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report and the photographs below.

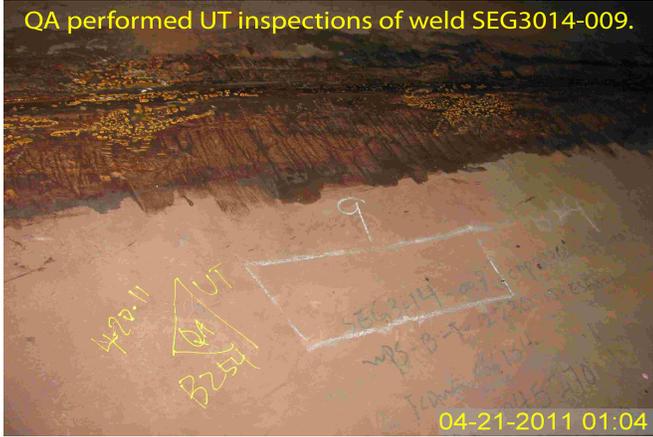
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# WELDING INSPECTION REPORT

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QA performed UT inspections of weld SEG3014-009.



## 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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Dawson,Paul

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer