

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000011**Date Inspected:** 14-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xie Ping**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:** N/A**Summary of Items Observed:**

Office of Structural Materials Quality Assurance Inspector (QA), David McClary observed quality control functions related to procedure qualification (PQR) testing at the ZPMC facility in Shanghai, Republic of China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item	Description	WBS	Dwg No.	Status
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1

The QA Inspector observed the following mechanical testing:

Retest on side bend specimen for 1G (Flat) Submerged Arc Welding (SAW) Minimum Heat Input Procedure Qualification (PQR) identified as HP-2006102 appeared to comply with the contract documents.

Charpy-V notch impact tests at non-FCM temperature for 1G Flux Core Arc Welding (FCAW) Maximum Heat Input PQR identified as HP-2006103 appeared to comply with the contract documents.

Retest of the All Weld Metal (AWMT) and side bend specimen for 1G FCAW Minimum Heat Input PQR identified as HP-2006104 did not appear to comply with the contract documents

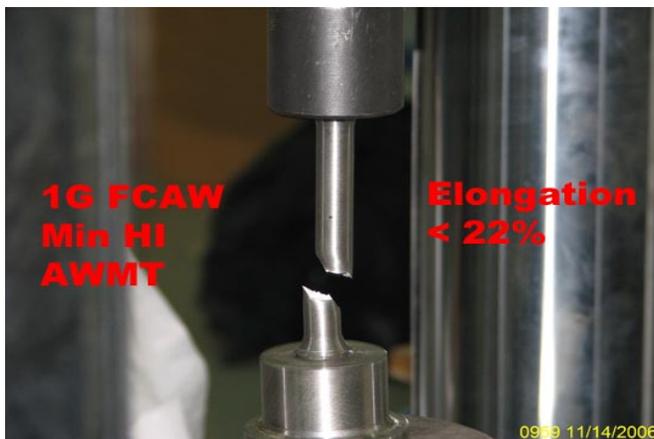
Complete initial mechanical testing of 3G (Vertical) FCAW Maximum Heat Input PQR identified as HP-2006105 appeared to comply with the contract documents.

Additional details on testing on TL-6031 and TL-6032's by QA Inspector Bruce Berger dated 11-14-06.

See following page for photos of testing operations.

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2

The QA Inspector performed a random check on machining operations at the Shan Xun Machine Co. of 3G FCAW PQR Minimum Heat Input PQR identified as HP2006106. All of the samples were identified as ?BBW 06?. The QA Inspector observed that all of the completed samples and those in the process of machining were marked with the same identification method detailed in their quality program. The QA inspector observed a slag inclusion in one of the Side Bend samples. Another sample was machined to replace the one with visible slag on the machined surface.

Below are photos of the shop facility under construction.

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Summary of Conversations:

The QA Inspector informed ZPMC Quality Control that he would like to look at the radiographic film for PQR HP-2006106 to see if the slag observed during the machining was visible on the radiograph. The QA Inspector was informed the film would be ready for his review on Wednesday, November 15, 2006.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: McClary, David

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer