

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-000064**Date Inspected:** 22-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**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:** Bid 52, 55 Tower and Girder**Summary of Items Observed:**

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The Caltrans Quality Assurance (QA) Inspector was present as requested to witness the mechanical testing of HP2006117, HP2006116, HP2006128 and HP2006133 Procedure Qualification (PQR) test plates. The QA Inspector also witnessed a second set of Charpy test for HP2006131. The QA Inspector observed tensile test on reduced sections and all weld metal specimens along with side bends, Charpy Vee Notch (CVN) and macro etch test. The test was performed per the AWS D1.5, Section 5.18 requirements. The test appeared to comply with the contract documents with the exception of HP2006116 and HP2006117 due to the Charpy Vee Notch (CVN) impacts were low. The ZPMC lab personnel stated that the samples would be removed from another part of the plates of 116 and 117. She also stated the CVN test would be performed tomorrow.

The re-test of CVN test ran on HP2006131 were found to be much higher than the first set by almost one hundred joules on average.

The Caltrans QA also had to point out to the Lab personnel performing the bend test, the requirements of spacing of the rollers during the test. The problem was corrected immediately and the test continued with no further infractions.

This was the second time that this QA Inspector had pointed this out to the lab personnel and warned of a Non Conformance Report (NCR), if this problem was to continue. The onsite Prime Contractor representative was also told of this problem.

Lot numbers issued were B41-023-07, B41-024-07, B41-025-07, B41-026-07 and B41-027-07.

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Summary of Conversations:

See Task Leader journal for this date.

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:	Wright,Mark	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
