

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-000067**Date Inspected:** 23-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Liu			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:	PQR		

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 re-testing of HP2006117 and HP2006116 Procedure Qualification (PQR) test plates. The QA Inspector witnessed a second set of Charpy test for HP2006116 and HP2006117. The test was performed per the AWS D1.5, Section 5.18 requirements at -30c. The test appeared to comply with the contract documents with the exception of HP2006117 due to the Charpy Vee Notch (CVN) impacts were low again. The ZPMC lab personnel stated that the HP2006117 would have to be re-welded.

The re-test of CVN test ran on HP2006116 were found to be much higher than the first set by over one hundred joules on average.

Lot numbers issued were B41-028-07 and B41-029-07.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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