

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000439
Date Inspected: 02-Sep-2007

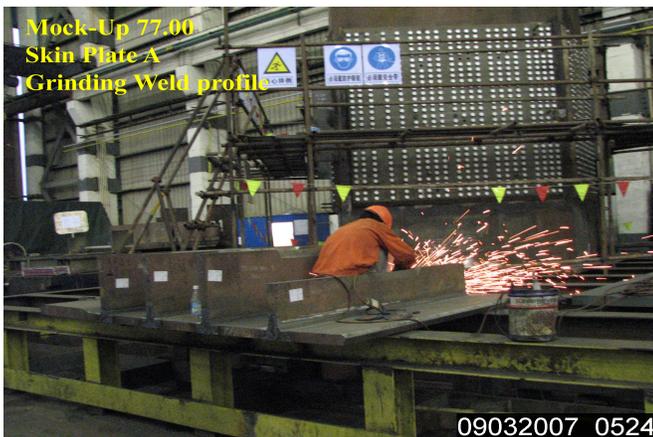
Project Name: SAS Superstructure **OSM Arrival Time:** 2330
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 800
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hou Jing Tao & Xu Bing	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No	N/A
		Component:	Caltrans Mock-Up 77.00 and 114.00		

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup and welding of the Caltrans Mock-up #77.00 and 114.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Mock-Up 77.00, skin plate A assembly: Caltrans QA Inspector observed ZPMC shop personnel perform weld profile grinding on the complete joint penetration welds, connecting stiffener plates to the skin plate. The cover pass surfaces of the welds are being ground smooth to blend smoothly into the plate surfaces with the transition areas being free from weld edge undercut. Following digital picture illustrates grinding in progress and weld profile, after grinding.



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Item	Description	WBS	Dwg No.	Status
1	Skin Plate D, 114 Mock-up	NA	NA	NA

Mock-Up 114.00, skin plate D assembly: Caltrans QA Inspector observed ZPMC perform tackweld removal at splice plate weld, weld number MUSC-MA 110-1 bottom. The assembly was observed to have a crack tackweld and appeared to be cracked the full length of the weld, and measured 178 mm in length. ZPMC elected to remove the tackweld by grinding. The weld excavation area and the remaining tackwelds were then magnetic particle tested by ZPMC QC testing technician, Mr. Cai Xin Xin. At the conclusion of the testing Mr. Cai Xin Xin stated that no relevant indications were observed and is accepted by ZPMC QC. ZPMC QA inspector, Mr. Zhang Jia di stated that this assembly would be turned over to the day shift for welding. Following digital pictures illustrate removal of the cracked tackweld and ZPMC magnetic particle testing.



Summary of Conversations:

As identified within the contents of this report.

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

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Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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