

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-000915**Date Inspected:** 10-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Cui Ri Yu**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:** Tower Mock-up and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

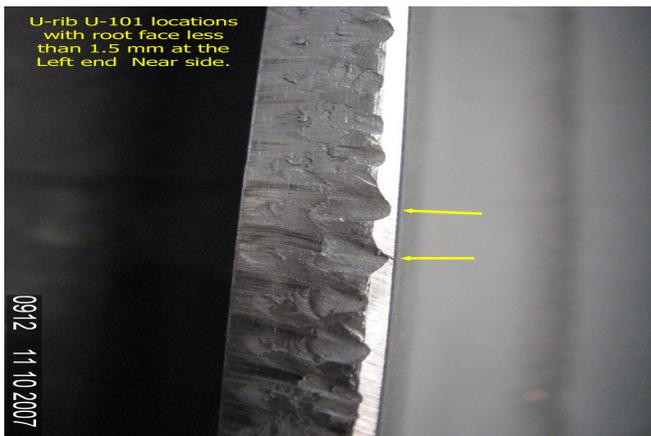
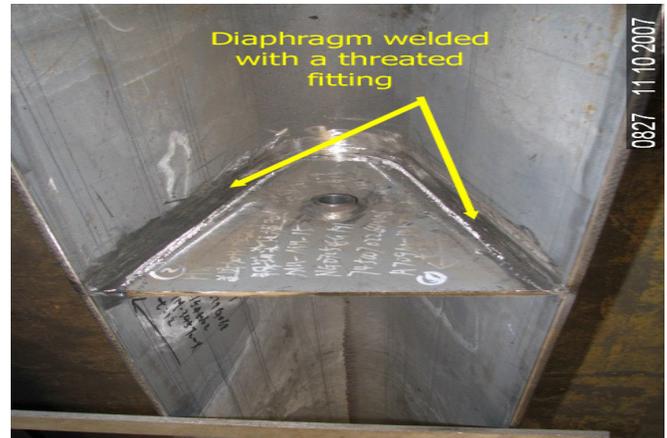
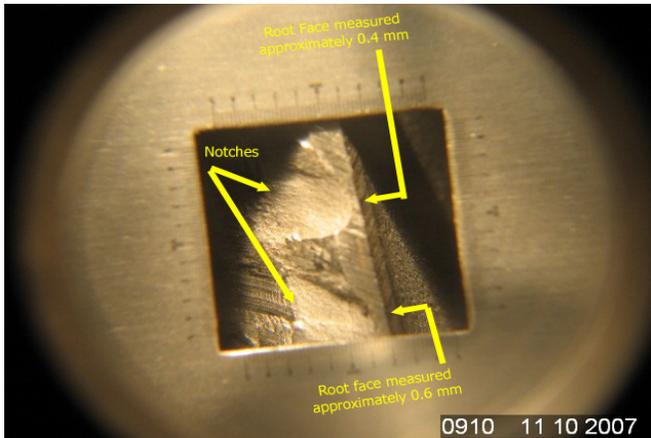
Item Description	WBS	Dwg No.	Status
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1	OBG Mock-up deck U-ribs		
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Caltrans representative Mr. Larry Viars and the QA inspector performed dimensional inspection to the root faces and the bevel angles on the OBG Mock-up U-ribs U-01 thru U-10. The QA inspectors found localized areas measuring less than 1.5 mm. The QA inspector had a conversation with the ABF representative Zhang Xu Liang and ZPMC representatives Hu Gang and Xu Jun. The QA inspector brought to the attention that the U-ribs U-01 and U-03 still have localized areas with root face that were measured less than 1.5 mm wide after ZPMC performed additional grinding. ABF and ZPMC agreed. ABF representative with Bureau of Veritas relayed to the QA inspector that he would relay this information to his supervisors. Mr. Xu Jun relayed to the QA inspector that ZPMC had already ground all the root faces of the ribs and that technical department would review the present condition. The digital photographs below show locations where the ZPMC performed additional grinding measuring and the root face measured less than 1.5 mm. Also a photograph show the a U-rib after ZPMC welded the internal diaphragm plates.

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4 OBG Bottom plate

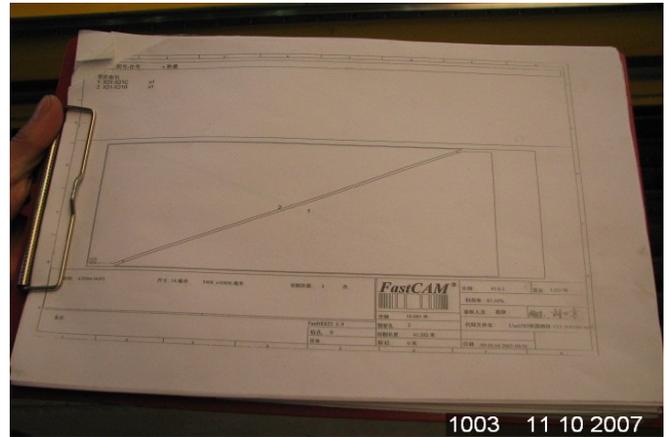
The QA inspector observed ZPMC performing fit-up operations at the bottom plate assembly panel PL 99A, SP59A at the junction of the Tee open ribs to the bottom plate. The QA inspector performed random dimensional verifications for the panel PL 99A, SP59A. The QA inspector found that the dimensions appears to be in compliance with ZPMC shop drawings.

6 OBG Material Verification at the ZPMC cutting table Tower Mock-up

The QA inspector observed the material being cut at the Tower Mock-up shop was A-709M-345F2-X for the plate designated as X21B-X21-C at the shop drawings. After verifying with the shop drawings, the QA inspector found that the material cut appeared to be in general compliance with the contract documents.

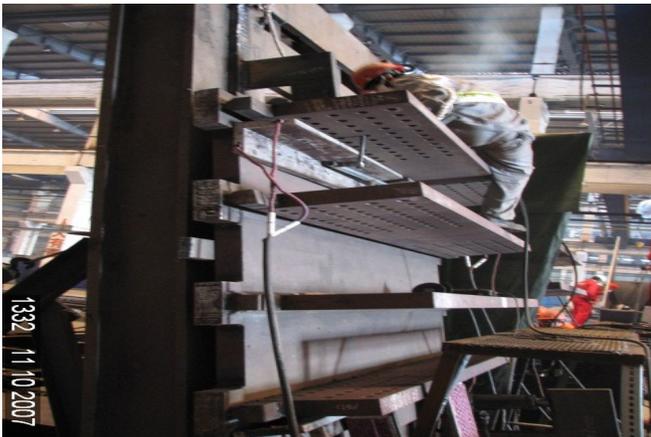
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7 Welding 114 M Interior Splices A-58 and A-75

The QA inspector observed ZPMC performing welding operations with the flux cored arc welding process on the 1G flat position to the interior splices A-58 weld joint # 1A, welder Xu Bo, welder ID # 040427 and interior splice A-75, weld joint # 1, welder Tao Quian, ID # 040457. The QA inspector performed random verifications of the welding parameters, preheat and interpass temperatures. The QA inspector found that the welding parameters, preheat and interpass temperatures appeared to be in accordance with the contract documents.



Summary of Conversations:

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

Inspected By: Acuna, Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer