

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-002049**Date Inspected:** 24-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Shi Lei**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-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77 meter Mock Up, Z. P. M. C. personnel are in the process of fitting up Skins A to E, weld number MUA-MA1-D/F-13B; A to B, B to C, C to D, weld number MUA-MA1-D/F-16B, MUA-MA1-D/F-16A; and D to E, weld number MUA-MA1-D/F-11B.

The QA Inspector Visually Inspected the bevel angle, bevel depth, and root gap of weld number MWT-18-13B. The bevel angle is 55 degrees to 60 degrees, bevel depth is 73 mm - 75 mm. Skin D to E, outside diameter bevel angle is 60 degrees, and inside diameter bevel angle is 40 degrees. Work is in progress.

Summary of Conversations:

No substantial conversations occurred between Quality Assurance Inspector M. Paul Stovall, and Z. P. M. C. QC personnel.

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:	Stovall,Paul	Quality Assurance Inspector
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Reviewed By:	Cochran,Jim	QA Reviewer
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