

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-002052**Date Inspected:** 16-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:** OBG Components, Tower Mock-Up**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.

(Bay 3) Z. P. M. C. Welder Han Jzanshe--066458, He Yemei,--048625, is tack welding back up bars and run-off tabs onto full penetration weld splices of W21 x 57's, for WT stiffeners for Side Plates (SP)009, SP013 and SP025.

Z. P. M. C. personnel are installing and turning heaters on for pre-heat prior to welding SP057--- at Gantry welder in Bay 3.

(Bay # 7) Z. P. M. C. welders, are welding lifting lugs onto Floor Beam (FB)015-04-023. Z. P. M. C. Quality Control (QC) personnel were present in the area, where the work was being performed.

(Bay #2)--QA Inspector Alfredo Acuna and QA Inspector M. Paul Stovall were asked by Z. P. M. C. QC personnel to perform an Ultrasonic Test and Visual Inspection on Skins A and C, for the 89 meter Tower mock-up, QA Inspector Acuna performed the Ultrasonic Test and QA Inspector M. Paul Stovall performed the Visual Inspection. On Skin C, there were (4) areas where material had been removed adjacent to the toe of the weld, that went below flush, generally in excess of 1mm, while there was (1) area, approximately 75 millimeters (mm) long that was (2+ mm) below flush, there was (1) slag indication, at the the end edge that had been partially ground out, but was still present, that would require to be filled, (1) area in a weld access hole--(rat hole), that needed to be filled, this was not excessive. There were (5) areas that needed to be ground to remove an "edge" that had been created in the weld bead, probably during the grinding that was done. On Skin A, there were (8) areas, (7) of

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which were on (1) plate that had had the area adjacent to the toe of the weld ground below flush, a minimum of (1 mm), all of these areas were less than (100 mm) long.

Summary of Conversations:

Caltrans QA Inspector, M. Paul Stovall spoke with Z. P. M. C., Certified Welding Inspector Xu Xianping, who acted as an interpreter about the weld profile on SP033.

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.

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