

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001413**Date Inspected:** 29-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

CWI Inspector: Hu We Ching

Bay 7

The QA Inspector performed dimensional inspections of Floor Beam plates detail "WT1" typical weld terminations. All "X" and "Y" measurements are being compiled on a spreadsheet that is to be submitted to Caltrans Engineering for evaluation

Bay 3

QA Inspector observed ZPMC welder Mr. Hong Zhi Wu stencil 59457 is using welding procedure specification WPS-B-T-2133 using the flux cored welding process for fillet welds on OBG closed rib weld DP057-001-171. The QA Inspector observed a welding current of approximately 200 amps, 24.0 volts and the base material has a minimum preheat temperature of 10° C. Items observed by the QA Inspector appear to comply with project

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specifications. See the photograph below for additional information.

ZPMC personnel are constructing additional camber fixtures that are to be used for securing orthotropic box girder side plates during completion of the stiffener plate welding, and no ZPMC personnel were observed to be welding Caltrans components in bay 3. See the photograph of ZPMC personnel constructing the new camber fixtures.



Summary of Conversations:

See above for summary of conversations.

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: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer