

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-001406**Date Inspected:** 11-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**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:** 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: Mr. Wu Ming Kai

Bay 3

The QA Inspector observed ZPMC personnel perform heat straightening of OBG side plate SP075 stiffener plates as directed by HSR(B)-035. This HSR has been approved by Caltrans Engineering 01-30-2008. The QA inspector observed ZPMC Quality Control personnel monitoring the heat temperature using a laser indicating device and the maximum temperatures that had had recorded are all less than the maximum limit of 600°C. See the photograph below for additional information.

The QA Inspector observed base plate BP019 with stiffer plate welds BP019-01-013 through BP019-01-024 clamped into a precamber table adjacent at the west overhead gantry welding station. ZPMC personnel used a laser device to measure the amount of camber that has been made in BP019. One person is aiming the laser light and the second person is using a scale to measure the amount of plate deflection. ZPMC personnel used See the

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photograph below for additional information.

The QA Inspector observed no other welding taking place in bay 3 due to the Chinese New Year Holiday.



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