

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-001517**Date Inspected:** 19-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Sha Zhi	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:	89M Mock-Up	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 corner 89M Mock-Up: Caltrans QA Inspector observed shield metal arc welding (SMAW) partial joint penetration (PJP) welding in progress. The assembly is identified weld joints are identified as MUB-MA21 J/J-16 & 17. The welders are identified as welder #070409063 and 066398, welding in the 3G (vertical position). The welders are using welding procedure specification WPS-B-T-4313-P5-12233-B-U2a-F, Revision 0. Caltrans QA observed ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi monitoring welding activities at the workstation.	NA	NA	welding in progress
2 PMT location marking OBG Bay 1: Caltrans QA Inspector performed Visual Test (VT) examination on the welds for Production Monitoring Test (PMT) for deck plate DP059. Caltrans QA Inspector witnessed ZPMC Quality Control Inspector, Mr. Fu Yu hong identify locations for test specimen removal for specimen #1, 2 and 3, in accordance with Caltrans Special Provisions requirements. Caltrans QA Inspector identified locations test specimens 4 and 5 for removal. The specimen locations were marked with a paint stick for future removal. The following digital picture illustrates the identification marking of the test specimens.	NA	NA	ZPMC QC

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
