

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-001663**Date Inspected:** 11-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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-up**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector witnessed ZPMC ultrasonic testing (UT) on the splice corner connection at the junction of the plate SA-194 to the p1083. ZPMC found the joint in compliance with the contract documents. The QA inspector observed that ZPMC UT verifications appeared to be in accordance with contract documents.

Note: The ZPMC had attached an intermittent backing bar to on the connection to meet the requirements of the joint configuration submitted and approved by the Engineer on this particular weld joint. This item had been addressed with an incident report issued by Caltrans representative Greg Bertlesman during fit-up operations. Caltrans QA inspector Joe Lanz and the QA Inspector had a conversation with ZPMC representative Xu Jun and QC inspector Li Li Ming. The QA inspectors asked why ZPMC did not mark the results of the test after completing the UT verifications (these verifications were made on several days upon the accessibility of the joints) on the skin plates corner complete joint penetration welds at skin plate B to C, assembly MA23 and MA24 and at skin plate C to D, assembly MA22 and MA23. ZPMC said that ZPMC completed their verifications but the marking was erased; ZPMC agreed that the rejectable indications were not marked because were located at the end of the joint.

The inspectors requested to ZPMC to see the ultrasonic testing (UT) reports for the joints tested. ZPMC showed and UT report signed and reviewed by ZPMC on 01-30-08 with the weld signed as acceptable. The QA inspectors asked why ZPMC completed UT examination on the skin C to D on 02/10/08 (according with ZPMC) and ZPMC had UT report accepting the weld on 01-30-08. See UT report attached. ZPMC did not answer.

