

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-002027**Date Inspected:** 08-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei, Xu Xianping**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:** 89-meter Mock-Up, OBG Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

89-meter Mock-Up, Z. P. M. C., personnel ground Skin Plate joint faces C – D and D – E joint.

Bay 1) Z. P. M. C. personnel milled each edge of unbent U-Ribs simultaneously. Z. P. M. C. personnel, after drilling bolt holes, deburred the bolt hole edges and the edge of the cut out “U” section, then using a crane with a magnetic lift, moved and stacked the pieces, five (5) high.

Z. P. M. C. Personnel drilled holes in unbent U-Ribs, at each end, on Piece numbers: U190, U191, U192, U193, U194, U182, U183, and U184.

Z. P. M. C. Welder Pan Ben Yang—067601, tack welded Plates 112 – 112A, and then welded the root, using Welding Procedure Specification (WPS)-B-T-2231-B-U2-F-1. The root was ground after welding.

Bay 3) Z. P. M. C. welders Xin Meng—053742, Li Shubing—048801, Dong Jinbao—049775, and Gu Caihong—053740, using WPS-B-T-2132-3, welded Side Plates (SP)048-01-(027-028), (019-020), and (015-016). The welding was done on the Gantry Welder. The QA Inspector checked and recorded the following WPS parameters: 314, 30.1; 310, 30.6; 308, 28.7; 318, 30.6; 297, 30.2; and 312, 30.7.

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Summary of Conversations:

The QA Inspector had no substantial 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:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
