

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-001564**Date Inspected:** 05-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Nan**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:** OBG Deck Plate**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

ZPMC CWI Wang Nan was present to monitor weld activities. Caltrans QA Inspector observed Gas Metal Arc Welding (GMAW) on root pass and Submerged Arc welding (SAW) on cover pass of Deck Panel DP032-001 and GMAW root pass on DP040-001. The welds are Partial Joint Penetration (PJP) welds, welded in the Horizontal 2G position. Welding was performed on a Gantry and operated by Ban Xiao Hui and weld operators Chen Jie # 059468, Xiang Jie # 059378, Zhang Shao Hui # 059403 and Xiany Huan Feny # 059416. Welders were using approved weld procedure WPS-B-T-2342-U1-3. Welding was completed on DP032-001 and root passes completed on DP-040-001.

DP032-001 U-Rib U-70 weld 1 was completed by Chen Jie and weld 2 by Xiang Jie, weld 3 on U-3 and weld 5 on U-14 was completed by Zhang Shao Hui, weld 4 on U-3 and weld 6 on U-14 was completed by Xiany Huan Feny. DP040-001 root passes on U-151 weld 1 and U-106 weld 3 was performed By Chen Jie. U-151 weld 2 and U-106 weld 4 was performed by Xiang Jie. U-135 weld 5 was performed by Zhang Shao Hui and weld 6 was performed by Xiany Huan Feny. An Incident report was written by QA Inspector Sherry Brannon due to ZPMC using one PMT panel for both deck panels.

Summary of Conversations:

As identified within the contents of this report.

WELDING INSPECTION REPORT

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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:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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