

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-001660**Date Inspected:** 07-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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:** OBG Deck panels**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 performed 50 % ultrasonic testing (UT) of the weld areas for the partial penetration joint (PJP) at the junction of the deck panel DP-062-001 to the U- ribs, weld joints # 1 thru 10. See the UT report TL_6027 generated on this date.

The QA inspector performed 100 % UT to the PJP on the production monitoring test (PMT) welded for the deck panel DP-041-001 and DP-066-001, weld joints # 1 thru 6. See the UT report TL_6027 generated on this date. A rejectable 4.3 mm lack of penetration with 8 mm of length and resulting in the depth of penetration (DOP) less than 70 % was found by ZPMC and verified by the QA inspector on weld # 6.

Note: In this date the QA inspector issued an incident report because ZPMC used deck panel as a ground connection for the welding power on ZPMC new shop bay # 2. The QA inspector had a phone conversation with ABF representative Warren Buehler. The QA brought to the attention of Mr. Warren Buehler about the issue describe above.

Summary of Conversations:

As note above.

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

WELDING INSPECTION REPORT

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for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer