

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-001975**Date Inspected:** 18-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 and OBG Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: Mr. Li Yanhua

Orthotropic Box Girder (OBG) and Tower Fabrication:

Bay 1

The QA Inspector performed ultrasonic inspections of OBG Deck plate closed rib complete joint penetration groove welds: DP327-001-154, DP327-001-155, DP327-001-156 and DP327-001-157. QA ultrasonic inspections reveal all four welds appear to comply with project specifications. These welds had been previously accepted by ZPMC QC personnel. See the TL-6027 "Ultrasonic Test Report" dated today and the photograph below for additional information.

The QA Inspector observed ZPMC welder Mr. Hao Long, stencil 59446 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG deck plate closed rib weld DP302-001-001. The QA Inspector observed a welding current of approximately 330 amps and 30.5 volts. Items observed by the QA Inspector appear to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

See above for summary of 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 Patrick Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
