

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-002069**Date Inspected:** 04-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1630**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:** See below**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:

Orthotropic Box Girder (OBG) and Tower Fabrication:

CWI Inspector: Sun Wei

Bay 1

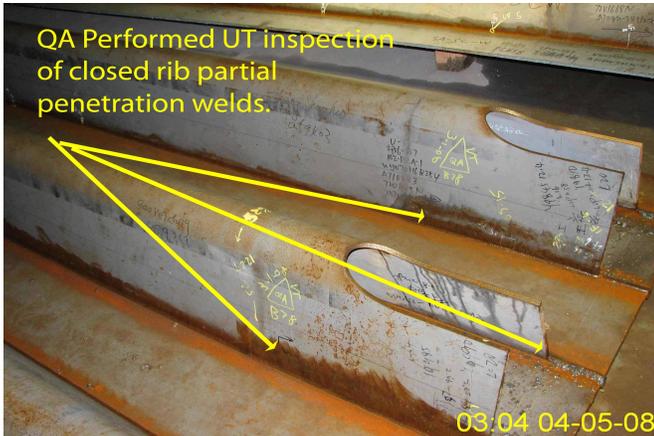
The QA Inspector observed ZPMC welder Mr. Shi Yunli stencil 59409 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG deck plate weld DP139-001-009 closed ribs. The QA Inspector observed a welding current of approximately 325 amps and 30.1 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Tang Ke stencil 62305 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG deck plate weld DP139-001-010 closed ribs. The QA Inspector observed a welding current of approximately 330 amps and 29.8 volts. Items observed by the QA Inspector appear to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA Inspector performed ultrasonic inspection of deck plate DP068-001 closed rib partial penetration welds #6 through #10. The purpose of this ultrasonic inspection is to determine if the completed closed rib welds have an adequate amount of penetration. The closed rib base material has a nominal plate thickness of 12 mm and the partial penetration welds are required to have a minimum of 80 percent penetration ie: 9.6 mm. Three of the five welds that were inspected today appear to have areas with less than 9.6 mm weld penetration, and the other two welds appear to have an adequate amount of weld penetration. The results of this inspection have been documented on QA Ultrasonic Inspection report titled: "04-0120F4_6027MOD_B63_04-04-08_ZPMC_DP068-001".



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 Lowey (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Hager,Craig	QA Reviewer
---------------------	-------------	-------------