

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002684**Date Inspected:** 23-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2030**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:

Orthotropic Box Girder (OBG) Fabrication:

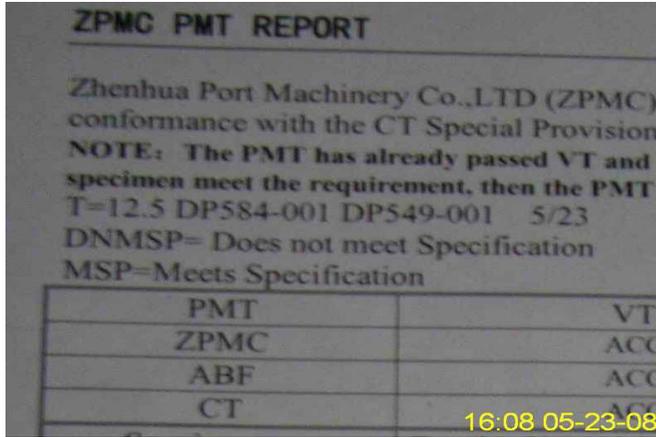
Production Monitoring Tests Macro Etches

The QA Inspector observed fifteen (15) each closed rib production monitoring tests (PMT) macroetch weld specimens representing deck plates DP-584-001 and DP-593-001 closed rib welds that were welded today are documented on a data sheet that is sitting in the QC office has been signed by ZPMC QC Mr. Duan Yabing and ABF representative Mr. Warren Buehler. The QA Inspector observed the "ZPMC PMT Report" document that has been signed by ZPMC and ABF representatives as being acceptable incorrectly lists deck plate DP-584-001 and DP-549-001, which were welded yesterday, instead of DP-548-001 and DP593-001 which were welded today. Mr. Yabing and Mr. Buehler had both left the site and the QA Inspector informed ZPMC QC CWI Inspector Mr. Wang Lu Testino of this problem. Mr. Testino researched the deck plate numbers and then he said he will find and correct the original PMT data sheet. The QA Inspector observed all fifteen macroetch specimens visually appear to comply with project specifications and contain weld penetration greater than 80 percent. The results of these inspections are documented on an Excel spreadsheet titled "SAS OBG PMT Macroetch Log" and a copy of this file is posted on the Caltrans "Team China" internal sever computer system. The QA Inspector also made

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digital photographs of each of the macroetch specimens and copies of these photographs will be posted on the Caltrans "Team China" common drive which is accessible to Quality Assurance Task Leaders and Structural Materials Representatives. Below is a digital photograph showing the incorrect weld numbers that are on the top of the original PMT data sheet.



Summary of Conversations:

See 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 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
