

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-002926**Date Inspected:** 26-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**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:

No Production Monitoring Test Macro Etch specimens were presented to the QA Inspector for visual inspections this shift.

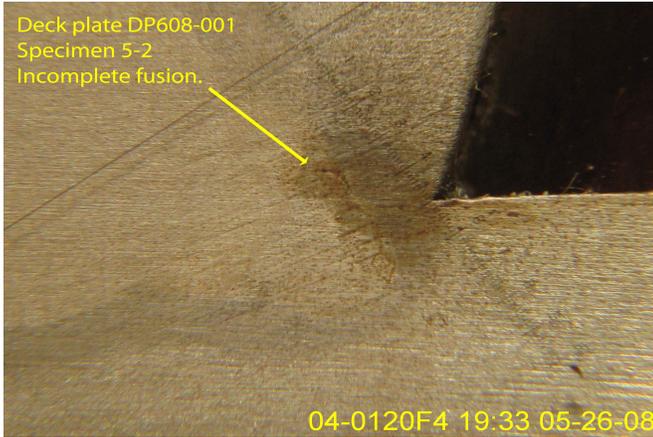
The QA Inspector performed digital photography of fifteen closed rib production monitoring tests (PMT) macro etch specimens representing deck plates DP-598-001 and DP-583-001 closed rib welds that were welded on May 24, 2008 and evaluated by the QA Inspector on May 25, 2008. The QA Inspector also took close up digital photographs of specimens 4-1 and 5-4 which appear to have incomplete fusion and a printed copy of these photographs have been placed in a two ring binder that is designated for the storage of closed rib rejected weld specimens in the QA office. Copies of these photographs are posted on the Caltrans "Team China" common drive which is accessible to Quality Assurance Task Leaders and Structural Materials Representatives.

The QA Inspector performed digital photography of fifteen closed rib production monitoring tests (PMT) macro etch specimens representing deck plates DP-608-001 and DP-564-001 closed rib welds that were welded and evaluated by the QA Inspector on May 25, 2008. The QA Inspector also took close up digital photographs of

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specimen 5-2 which appears to have incomplete fusion and a printed copy of this photograph has been placed in a two ring binder that is designated for the storage of closed rib rejected weld specimens in the QA office. Copies of these photographs are posted on the Caltrans "Team China" common drive which is accessible to Quality Assurance Task Leaders and Structural Materials Representatives. Below is a photograph of specimen 5-2 which appears to have incomplete fusion.



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
