

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-002837**Date Inspected:** 05-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 and Tower**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 ultrasonic testing (UT) at the completed joint penetration at the diaphragm plates splices for weld joints # WSD1-SA-78-1B/1A, SSD1-SA20-110B, WSD1-318-A/B 3A/4A, WSD1-SA-238-A/B-3A/4A and ESD1-318-A/B-4B/3B. The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. However the QA inspector found a class A rejectable indication at the end of the weld joint SSD1-SA20-110B. The QA inspector had a conversation with ZPMC representative Lay Tao. Mr. Lay tao informed the QA inspector that ZPMC found the indication too but ZPMC did not mark it because ZPMC planned to trim the ends approximately 50 mm. The QA inspector brought to the attention of Caltrans task Leader Robert Cuellar. Mr. Robert Cuellar agreed to track the indication and confirm that ZPMC trim the end removing the indication. See UT report TL_6027 generated on this date.

The QA inspector performed thickness verification at the deck panel DP-609-001 at the tack weld # 24 from weld joint # 6 by the area where the base metal was excavated after removing a linear indication on this tack weld. The QA inspector found a minimum of 11.52 mm at the excavated area and 14.02 appeared to be the average thickness on the general area. The depth of excavation was reported approximately 2.5 mm.

The QA inspector performed UT at the completed joint penetration at the floor beams connections weld joints # FB-003-12-1(bottom flange Floor beam FL-2-1 bottom flange splice), SSD12-PP028-006(jointing connection plates to floor beam bottom flange) and SSD11A-PP027-006(jointing connection plates to floor beam bottom

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

flange) and SSD13A-PP023-132 (jointing connection plates to floor beam bottom flange). The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL_6027 generated on this date.

Summary of Conversations:

As noted 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 for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Cuellar,Robert	QA Reviewer
---------------------	----------------	-------------