

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-002839**Date Inspected:** 02-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 UT at the completed joint penetration at the side plates splices weld joints # SEG-019A-021 (jointing side plates SP62A/SP50A), SEG 013A-014 (jointing side plates SP-45B and SP-33B) and SEG-013A-013 (jointing side plates SP-45B and SP-57B). 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.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the skin plates splices weld joints #ESD1 SA-237-A/F 2A, ESD1 SA107A A/J-19B, ESD1-SA107 A/J-18A, 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:

The QA inspector informed Task Leader Robert Cuellar and Assistance of Structural Materials Representative Joshua Isibashi that ZPMC fitted and welded 5 from 7 weld joints (the diaphragm ring was not fitted/welded on weld joints # 3 and 7) on the doubler diaphragm ring SA-266 subassembly for the diaphragm ESD1-SA32, and ZPCM appeared was not following a same progressive welding sequence used on others diaphragm rings to avoid weld distortion. Mr. Joshua Isibashi informed that he would asked to the Structural Materials Representative

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Ryan Smith about this matter.



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
