

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-003052**Date Inspected:** 03-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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 closed rib Production Monitoring Tests Macro Etch specimens were presented to the QA Inspector for inspections this shift.

New Tower Shop Bay 1

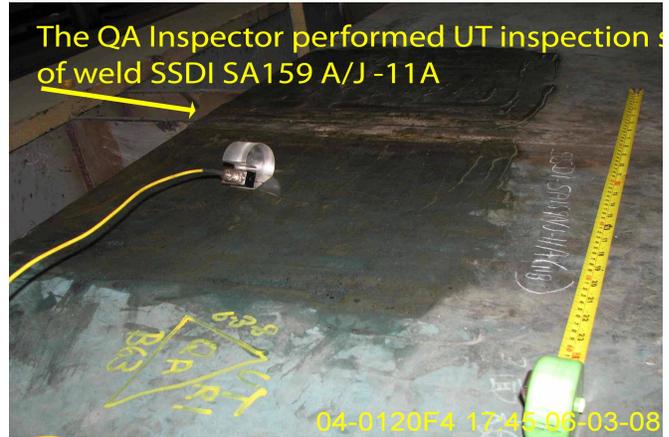
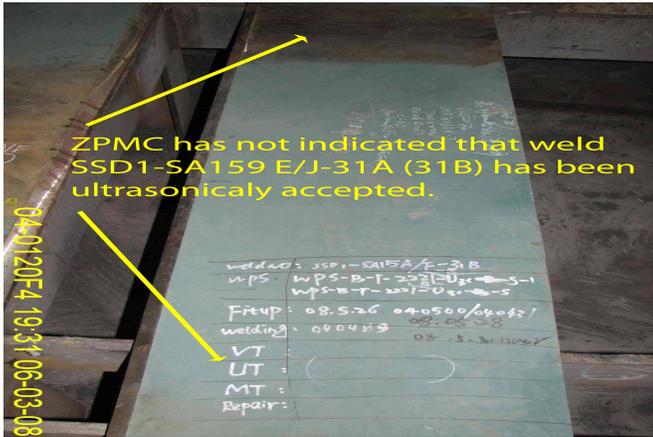
Earlier today ZPMC presented Caltrans with "The Notification of Witness Inspection" document 00473 which states Final UT for welds SSD1-SA159 E/J-23A (23B), 24A (24B), 7A(7B), 10A (10B) 19A (19B) and 31A (31B) are to be ultrasonically inspected at 0900 hours today. QA visual inspection of the above listed welds at around 1600 hours revealed welds 23A (23B) and 24A (24B) have not been fully welded and welds 7A (7B), 10A (10B), 19A (19B) and 31A (31B) do not have a ZPMC UT inspection signoff to indicate they are ultrasonically acceptable. See the photograph below showing weld SSD1-SA159 E/J-7A 31A (31B) which has not been marked as being UT inspected.

The QA Inspector completed ultrasonic inspection of tower south skin diaphragm welds SSD1-SA159 A/F-32A

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(32B) and SSD1-SA159 A/J-11A (11B) and both welds appear to comply with AWS D1.5 requirements. See the TL6027 Ultrasonic Test Report dated today and the photograph below of weld 11A for additional information.



Summary of Conversations:

No significant conversations occurred.

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
