

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-003564**Date Inspected:** 23-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 Assembly**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Vatcher, 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: The weather today is 27C and clear.

Caltrans Quality Assurance (QA) Inspector Robert Vatcher, 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: The weather today is 27C and clear.

QA performed ultrasonic testing (UT) in Bay 3 on the following OBG Bottom Plate piece marks for compliance with the contract documents.

BP309-001-037 which supports 10% for welds 039, 041 & 043

BP310-001-037 which supports 10% for welds 039, 041 & 043

BP312-001-033 which supports 10% for welds 035, 037 & 039

BP313-001-039 which supports 10% for welds 033, 035 & 037

Bay 4

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

QA attempted to perform Magnetic Particle examinations (MT) for Bottom Plate BP194-001-007 but was explained to by AB/F QC that the piece mark was no longer in Bay 4 and could not be located at this time.

Bay 7

QA performed ultrasonic testing (UT) in Bay 7 on the following OBG Floor Beam piece marks for compliance with the contract documents.

SSD12-PP034-135
SSD12A-PP034-006
SSD10-PP038-132

Heavy Shop 1

QA performed ultrasonic testing (UT) in Heavy Shop 1 on the following Tower Plate piece marks for compliance with the contract documents;

SSD1-SA40C/ E-32 A/B

Heavy Shop 2

QA performed ultrasonic testing (UT) in Heavy Shop 2 on the following Tower Plate piece marks for compliance with the contract documents;

ESD1-SA80A/ E-41A, 41B which supports 10% for weld E24A, 24B & E-10A, 10B.

OBG Assembly Shop

QA performed ultrasonic testing (UT) in OBG Assembly Shop on the following piece marks for compliance with the contract documents;

SEG015B-002
SEG015B-027
SEG015B-011

The above mentioned items as observed and examined by QA appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
----------------------	----------------	-----------------------------

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