

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-003679**Date Inspected:** 18-Aug-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:** Mr. Sun Bo**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 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):

Heavy Tower Bay #3:

Around 1900 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC QC and ABF QA Inspection personnel are going to perform final visual inspections of closed rib welds on deck plate DP029-001. Following ZPMC and ABF Inspectors acceptance of these welds the QA Inspector performed random visual inspections and observed an arc strike on the base material near weld #1 and the other welds appear to comply with project specifications. The QA Inspector informed ZPMC QC Inspector Mr. Sun Bo of the arc strike and he had it removed. Mr. Bo said that dayshift personnel will perform magnetic particle inspection of the arc strike removal area. The QA Inspector documented the visual inspection of the welds on the yellow "SFOBB QA Verification In Process" tags attached to each of the deck plates adjacent to where ZPMC and ABF Inspectors had documented their inspections.

Around 2000 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC QC and ABF QA Inspection personnel are to perform final visual inspections of closed rib welds on deck plate DP018-001 and

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DP270-001 and they will then be ready for QA personnel to perform visual inspections of the welds.

Following ZPMC and ABF Inspectors acceptance of these welds the QA Inspector performed random visual inspections of DP018-001 and items appear to comply with project specifications. The QA Inspector documented the visual inspection of the welds on the yellow “SFOBB QA Verification In Process” tag attached to the deck plate adjacent to where ZPMC and ABF Inspectors had documented their inspections

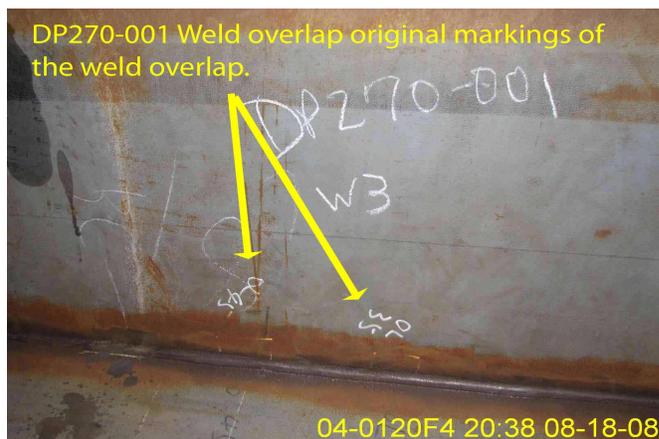
Following ZPMC and ABF Inspectors acceptance of these welds the QA Inspector performed random visual inspections of DP270-001 and observed previously marked overlap on weld #3 has not been removed. ZPMC Inspector Mr. Sun Bo said this overlap is not going to be removed since it had not been marked during the recent “Initial Visual” inspections. The QA Inspector did not initially accept the final visual inspections on the yellow “SFOBB QA Verification In Process” tag. The QA Inspector informed ABF/Fluor Inspector Mr. Kevin Dye that ZPMC refused to remove the overlap. At 2125 hours the ZPMC bay 3 heavy shop foremen informed the QA Inspector he has had the weld overlap removed and the QA Inspector confirmed the overlap has been removed. The QA Inspector documented the visual inspection of the welds on the yellow “SFOBB QA Verification In Process” tag attached to the deck plate adjacent to where ZPMC and ABF Inspectors had documented their inspections.

Bay 3

The QA Inspector performed ultrasonic inspections of the entire length of base plate BP309-001 weld 037, BP310-001 weld 037 and BP312-001 weld 037 and items appear to comply with project specifications. ZPMC is required to perform inspections of minimum of 25% length of each weld and ZPMC has the option to perform inspections of 100% length of one weld instead of partial length inspections of four separate welds. ZPMC inspected the full length of weld 037 on each of the three base plates and is taking credit for welds 039, 041 and 043. See the TL6027 ultrasonic test report for additional information.

Bay 7

QA performed ultrasonic inspection of approximately 10% length of floor beam FB020-001 welds 78, 79, 80, 81, 101, 108, 117, 122, 125, 126 and 127 and items appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.



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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 Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
