

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-003682**Date Inspected:** 21-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**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:** See below**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:

CWI: Mr. Li Yan Hua and Mr. Sun Bo

Orthotropic Box Girder (OBG):

Heavy Tower Shop #3:

Around 1500 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC QC and ABF QA Inspectors will be conducting initial visual weld inspections of deck panels DP548-002, DP589-001 and DP579-001 in heavy tower bay #3. Following QC Inspector Mr. Li Yan Hua and ABF Inspector Mr. Wang Zhong Yuan inspecting and marking the weld defects the QA Inspector performed visual inspections of the three deck panel welds. The QA Inspector observed several welds in DP548-002 had a substantial amount of grinding debris and dirt obscuring the bottom toe of several welds. The QA Inspector informed Mr. Wang Zhong Yan and Mr. Li Yan Hua that portions of the weld are obscured due to this debris and dirt. Mr. Hua said he will have the weld surfaces cleaned and the areas will be reinspected. The QA Inspector observed and marked several areas of weld overlap in deck panel DP548-002 and the QA Inspector informed Mr. Hua that this overlap had not been marked by the ZPMC QC and ABF QA Inspectors. Following QA completion of the initial visual inspections of the deck

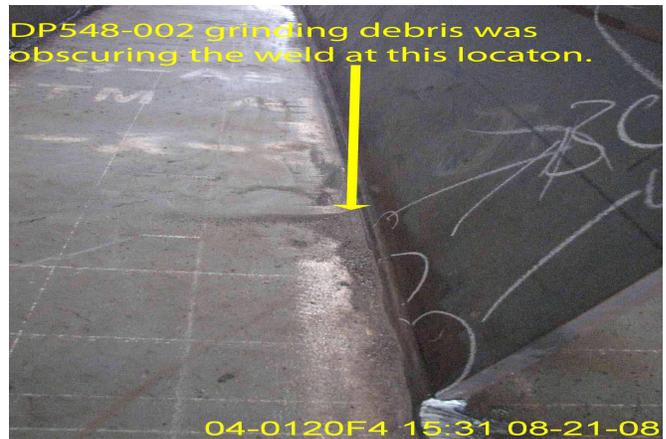
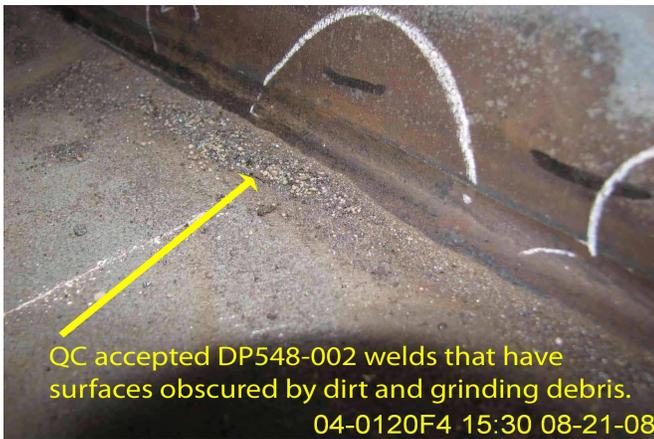
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panels the QA Inspector documented the initial visual inspections on the yellow inspection status tag that is attached to each of the three deck panels.

Bay #1

Around 1830 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that at 1900 hours ZPMC QC and ABF QA Inspection personnel will be conducting initial visual weld inspections of deck panel DP069-001 in bay #1 and it will then be ready for QA Inspection. Following ZPMC QC Inspector Mr. Sun Bo and ABF Inspector Mr. Ding Bao hua marking the weld defects the QA Inspector performed random visual inspections of deck panel DP069-001 and the QA Inspector concurred with the areas that had been identified as needing repairs. Following QA completion of the initial visual inspections the QA Inspector, the QA Inspector documented the initial visual inspections on the yellow inspection status tag that is attached to the deck panel.



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
