

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-003707**Date Inspected:** 25-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:

Orthotropic Box Girder (OBG) and Tower:

Bay 7

The QA Inspector performed AWS D1.5 ultrasonic inspection of Floor Beam welds FB019-001-148 and FB029-001-146 following ZPMC ultrasonic acceptance of these welds. Items observed appear to comply with project specifications.

Bay 8

QA performed AWS D1.5 ultrasonic inspection of 100% length of tower flange welds NSD1-SA169A/B-2A/B and NSD1-SA169A/B-3A/B ZPMC following ZPMC ultrasonic acceptance of these welds. ZPMC is required to perform 25% UT inspections of welds 2, 3, 4, 5, 6, 7, 10 and 11 and ZPMC has the option to perform UT of 100% length of 2 welds and not inspect the other six welds. ZPMC took this option and only ultrasonically inspected welds 2 and 3. Items observed appear to comply with project specifications.

WELDING INSPECTION REPORT

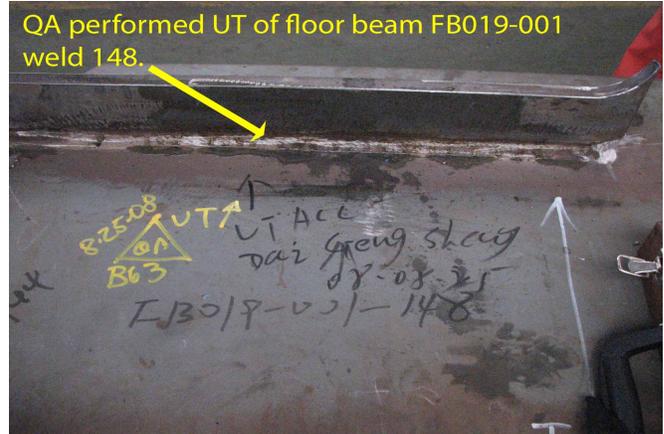
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Heavy Bay 1

QA determined QC has UT rejected tower skin E repair weld WSDI-SA39A/K-15a (B). This will be the second repair of this weld.

Heavy Bay 2

QA performed ultrasonic inspections of 100% length of tower stiffener splice welds SSDI-SA180D/E 12A (B), SSDI-SA180D/E-14A (B), SSDI-SA180C/E 4A (B), SSDI-SA180C/E 5A (B) and, SSDI-SA40A/E 6A (B). All items appear to comply with project specifications.



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
