

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-003975**Date Inspected:** 15-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**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:** An Qing Xiang**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 and Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform random inspections of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly Shop Bay 2:

The Caltrans QA Inspector recorded weld repair progress of crack areas associated with tack welds on OBG Deck Panels DP053-001, DP054-001 and DP055-001 U-rib PJP welds. Repairs were completed on DP053-001. Repairs of DP054-001 and DP055-001 had not been completed. ZPMC personnel were not observed performing repairs on the night shift.

Heavy Machinery Shop Bay 2:

The Caltrans QA observed welder stencil numbers 068864, 068919, 046736 and 068917 performing semi automated Flux Cored Arc Welding in the 2G position on Tower Skin Plate C Longitudinal Stiffener Partial Joint Penetration (PJP) welds ESD1-SA77 A/E 52, 53, 58 and 59 and ESD1-SA294 A/G 31, 32, 37 and 38. The QA Inspector observed ZPMC personnel performing interpass cleaning between weld passes and ZPMC CWI Mr. An Qing Xiang periodically monitoring welding operations. The above mentioned welding appeared to be compliant with the posted Welding Procedure Specification, WPS-B-T2332-B-TC-P5-F.

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No other activities observed.

Summary of Conversations:

Only general conversations occurred between QA and QC 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 remedial efforts please contact Ady Velasco 138 1694 2685, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
