

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-004055**Date Inspected:** 09-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**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. Liu Hua Jie**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:

Bay 8

ZPMC notification of witness inspection document #01002 dated 9-09-2008 states that ZPMC QC inspection personnel will be conducting final magnetic particle inspections of tower diaphragm weld WSD1-SA290-13A/B. ZPMC has marked this weld as being VT, MT and UT accepted. The QA Inspector performed random visual inspections of this weld and observed the weld terminations have flame cuts and portions of the weld terminations have an oxide covering that obscures the weld surface. The QA Inspector informed ZPMC CWI Mr. Liu Hua Jie who agreed the weld terminations are not visually acceptable. Mr. Jie said these weld terminations will be repaired and new MT and UT inspections will be performed.

Bay #4

The QA Inspector performed random magnetic particle inspections of the following OBG end plate welds:

EP-180-001-002 & EP-180-001-015

EP-182-001-002 & EP-182-001-013

Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay #7

The QA Inspector performed random magnetic particle inspections of the following OBG corner diaphragm welds:

CSD004-PP040-096 & CSD004-PP040-097
CSD006-PP030-095 & CSD006-PP030-096
CSD006-PP035-095 & CSD006-PP035-096
CSD006-PP036-095 & CSD006-PP036-096
CSD006-PP031-095 & CSD006-PP031-096
CSD005-PP037-035 & CSD005-PP037-036
CSD005-PP045-096 & CSD005-PP045-097
CSD005-PP033-097 & CSD005-PP033-098
CSD005-PP039-100 & CSD005-PP039-101
CSD008-PP042-001 & CSD008-PP042-002
CSD005-PP047-033 & CSD005-PP047-034
CSD005-PP043-035 & CSD005-PP043-036
CSD005-PP041-033 & CSD005-PP041-034
CSD008-PP041-001 & CSD008-PP041-002
CSD008-PP043-001 & CSD008-PP043-002
CSD005-PP029-033 & CSD005-PP029-034
CSD005-PP031-035 & CSD005-PP031-036
CSD005-PP035-033 & CSD005-PP035-034
CSD015-PP047-193 & CSD015-PP047-194
CSD015-PP037-187 & CSD015-PP037-188
CSD006-PP029-095 & CSD006-PP029-096
CSD007-PP030-033 & CSD007-PP030-034
CSD007-PP042-033 & CSD007-PP042-034

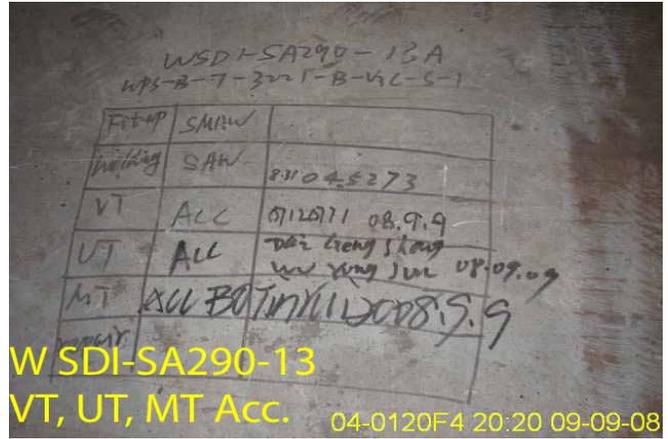
Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

Heavy bay 3

The QA Inspector performed initial visual inspections of the welds of deck panel DP553-001 and DP609-001 in heavy tower bay #3. The QA Inspector marked a few additional areas of weld overlap and underfill. The QA Inspector documented the initial visual inspection on the yellow inspection status tags that are attached to the deck panels.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
