

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-004062**Date Inspected:** 02-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	AB/F Li Hanjie ZPMC Shen Fu YC			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 Assembly		

Summary of Items Observed:

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher 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:

QA observed the lifting and fit-up of LD2A weld number four between panel point 24 for lift 4BW. QA verified bevel angle and root opening to be within tolerances set forth in AWS D1.5 (2002).

QA performed WPS verification for 4BW floor beam FB5B welds 30 and 130 to WPS-B-T-2233-B-U2a-F. Amperage was measured at 275; Voltage at 29.5 and travel speed at 365 mm per minute for welding electrode E71-T1.

The above mentioned items as observed by QA appear to be in conformance with the contract documents.

Summary of Conversations:

See above for situational specific conversation summaries.

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.

WELDING INSPECTION REPORT

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Inspected By:	Vatcher,Robert	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
