

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-004597**Date Inspected:** 13-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**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:****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 & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate	NA	NA	QA-UT

Tower

Heavy Shop 2: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001412. The subassembly is identified as Lift 1, shin plate D, welds

WSD1-SA80A/E-42B and WSD1-SA80A/E-45B. Caltrans QA inspector observed that the welds have been UT inspected and accepted by ZPMC QC. Caltrans QA-UT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 13, 2008 for additional information. The following digital picture illustrates inspected weld WSD1-SA80A/E-54B.

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|---|-------------------------|----|----|-------|
| 2 | OBG Deck Panel
Tower | NA | NA | QA-MT |
|---|-------------------------|----|----|-------|

Heavy Shop 3: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001411. The subassemblies are identified as OBG deck panels; weld DP090-001-001, 002, 003, 004, 005 and 006 partial joint penetration cover pass welds joining u-rib to the deck panel plate. Also, deck panel welds DP117-001-001, 002, 003, 004, 005, 006, 007 and 008. Caltrans QA inspector observed that the welds have been MT inspected and identified as accepted by ZPMC QC. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, November 13, 2008 for additional information. The following digital picture illustrates inspected deck panel DP117-001.



Summary of Conversations:

As identified within the contents of this report.

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.

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