

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004624**Date Inspected:** 14-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:** Tower & OBG**Summary of Items Observed:**

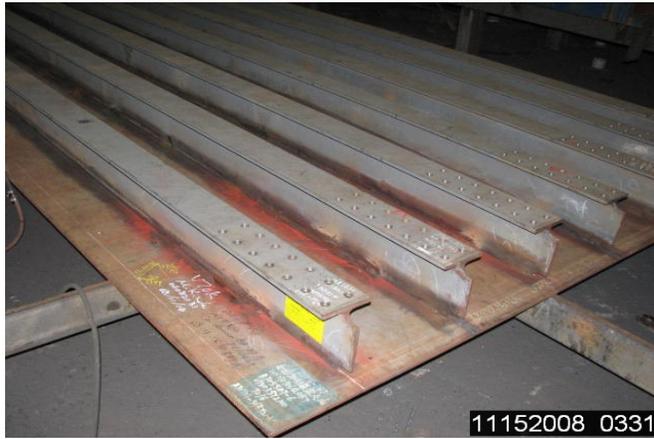
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company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

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate Tower Heavy Shop 2: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001422. The subassemblies are identified as Lift 1, skin plate B, weld WSD1-SA279A/H-10A, Lift 1, skin plate D, weld WSD1-SA80A/E-45A and Lift 1, skin plate E, weld WSD1-SA225A/H-8B. Caltrans QA inspector observed that the welds have been MT inspected and accepted by ZPMC QC inspector, Mr. Cai Xin Xin. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 14, 2008 for additional information.	NA	NA	QA-MT
2	OBG Side Plate Bay 4: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001422. The subassembly is identified as Side Plate SP539, welds SP539-001-015, SP539-001-016, SP539-001-017, SP539-001-018, SP539-001-019, SP539-001-020, SP539-001-021, SP539-001-022, SP539-001-023, SP539-001-024, SP539-001-025, SP539-001-026, SP539-001-027 and SP539-001-028. QA inspector observed that the welds have been MT inspected and identified as accepted by ZPMC QC, Mr. Cai Xin Xin. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project	NA	NA	QA-MT

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, November 14, 2008 for additional information. The following digital picture illustrates inspected weld Side Plate SP539-001 welds.



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.

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