

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-004663**Date Inspected:** 13-Nov-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:	Geng Wei, Zhang Bao Wei			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:

OBG Assembly Bay II

5AE- No Observed Welding Activity

5BE- No Observed Welding Activity

5CE- No Observed Welding Activity

3AE- No Observed Welding Activity

3BE- No Observed Welding Activity

4AE- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity elsewhere as well.

4BE- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Observed Welding Activity elsewhere as well.

Mid bay-

NPI of Oregon continues to provide support for various Deck Panel U-rib tack weld crack evaluations by the Phased Array Ultrasonic Method. As well repair work continues by ZPMC laborers on these same components.

5CW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. QA Observed Welding Activity at the Longitudinal Diaphragm to bottom plate and Longitudinal Diaphragm to Floor Beam locations by way of the FCAW process. QA performed magnetic Particle (MT) examinations on longitudinal diaphragm stiffener plates at LD005-001/ 002, LD007-001/ 002, LD001-005 001/ 002, LD002-005 011/ 012 in order to facilitate the green tagging process which is to be conducted this afternoon with AB F representative Warren Buehler.

5BW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity elsewhere as well. QA performed magnetic Particle (MT) examinations on longitudinal diaphragm stiffener plates at LD009-003 001/ 002, LD003-010-001/ 002, LD004-010 001/ 002, LD0034-009 001/ 002 and LD003-009-001/ 002 in order to facilitate the green tagging process which is to be conducted this afternoon with AB F representative Warren Buehler.

5AW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity

4BW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity

4AW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity

3BW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity

3AW- No deck panel to deck panel or diaphragm plate to floor beam flange welding occurring as of this time. No Observed Welding Activity

North Bay of OBG Assembly- No Observed Welding Activity

Summary of Conversations:

No relevant conversations 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 Peter Dauterman, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Vatcher,Robert

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer