

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-004707**Date Inspected:** 20-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**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:	NA	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:

OBG Bay #7

This QA Inspector performed random final visual and magnetic particle (MT) inspections of welds on Floor Beams FB012-021, FB012-020, 016-023, 013-026, FB010-012 and FB010-021 and documented the MT inspections on yellow tags that are attached to each of the floor beams. The QA Inspector observed the welds appear to comply with project specifications. For additional information on these inspections see the TL6028 magnetic particle Test Report. ZPMC Notification of Witness Inspection #1459 indicates all of the floor beams on the notification list are presented for green tagging and it appears this is a typographic error since the signoff on the yellow tags for the upper and lower sides of each of the floor beams are incomplete. Weld FB010-012-043 is marked as a UT reject and it does not appear to have been repaired. See the TL6028 Magnetic Particle Test Report for additional information.

This QA Inspector performed random final visual and magnetic particle (MT) inspections of welds on Floor Beam weld FB011-013-045 and documented the MT inspections on the yellow tag that is attached to the floor beams. The QA Inspector observed the weld appears to comply with project specifications. Both yellow tags for the upper and lower sides of the floor beams are now completed and the QA Inspector approved green tagging #1877 for this

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floor beam. See the TL6028 Magnetic Particle Test Report for additional information.

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
