

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021669**Date Inspected:** 08-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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**Summary of Items Observed:**

CWI Inspector: Mr. Bao Qian

On this date CALTRANS OSM 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. This QA Inspector observed the following:

OBG Bay 14

TC-RFI-0043R0

This QA Inspector performed random document review of "Team China request for information (TC-RFI)" document #TC-RFI-0043R0. This RFI addresses installation of fit lugs between OBG 13W and near panel point 119. The following observations were made concerning this RFI:

Segment 13C East

Installation of type 13 fit lugs between stiffener plates and floor beams at segments 3011L PP122.5, 3011J PP123, 3011G PP123.5, 3011E PP124 and 3011C PP124.5 and installation of type X3627 lugs at panel points PP123 and PP124.

East: type X3627 lugs are not installed at panel points PP123 and PP124, and Type 13 Fit Lugs are installed at the locations noted above.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 13C West

Installation of type 13 fit lugs between stiffener plates and floor beams at segments 3015K PP122.5, 3015H PP123, 3015F PP123.5, 3015D PP124 and 3015B PP124.5 and installation of type X3627 lugs at panel points PP123 and PP124.

West: No fit lugs installed at any of the locations noted above.

This QA Inspector took random photographs of some of these items and copies of the photographs and other related information have been placed in "TC-RFI Documentation" folder located on Team China common Z drive pending engineering review. See the photographs below for additional information.

TC-RFI-0041R0 (Hinge pipe)

This QA Inspector performed random document review of "Team China request for information (TC-RFI)" document #TC-RFI-0041R0 and TC-RFI-0041R1. This RFI addresses installation of pipe sleeves at OBG segments 14 East and 13 West near panel point 128.

The following observations were made concerning this RFI:

Item 1 of the RFI addresses vertical and horizontal stiffener configuration at the left and right sides of the sides of the pipe sleeves and having a 150mm clearance gaps at this location. The RFI also addresses use of a CJP with backing on the vertical stiffeners in between horizontal stiffeners. This QA Inspector observed ZPMC appears to have installed the stiffeners as referenced in the RFI and that the pipe sleeve clearance dimensions vary between 148mm and 158mm.

Item 2 of the RFI addresses increasing the gap between the pipe sleeve and the triangular shaped stiffeners to 80mm near panel point PP127. This QA Inspector performed random measurements of these gaps and observed the maximum gap appears to be approximately 78 mm.

Item 3 of the RFI addresses pipe sleeve slotted holes. This QA Inspector performed random measurements of these slotted holes and observed the sizes of the holes appear to be approximately 108mm long and 70mm wide.

This QA Inspector took random photographs of some of these items and copies of the photographs and other related information have been placed in "TC-RFI Documentation" folder located on Team China common Z drive pending engineering review.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer