

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000843**Date Inspected:** 19-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hou Jing Tao**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 U-Rib Trial Assembly**Summary of Items Observed:**

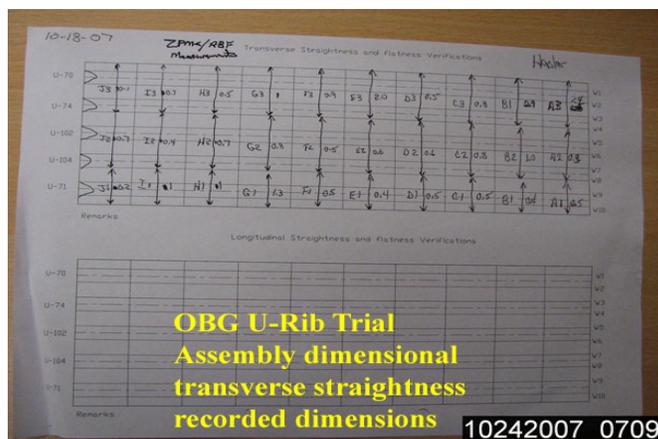
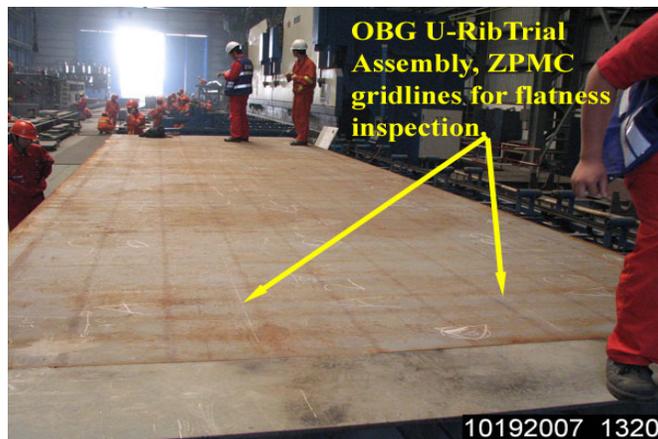
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 OBG U-rib Trial Assy	NA	NA	Deck Plate Flatness

OBG U-Rib Trial Assembly: Caltrans QA Inspector witnessed ZPMC move u-rib trial assembly from the welding jig. The u-rib trial assembly was then flipped over to the deck side and moved to the back of the shop for ZPMC to perform dimensional inspection of the assembly for straightness and deck flatness. Caltrans QA Inspector observed and recorded ZPMC flatness measurements of the deck plate. Caltrans QA Inspector observed that ZPMC Quality Control (QC) inspectors established a transverse and horizontal gridline on the top surface of the deck plate. The welded, unstraightened panel gridline divisions were observed to be marked at 1000mm increments. The observed flatness dimensions as measured transverse to the ribs appeared to be in conformance within the Special Provisions requirements, 3mm in 1000mm. The recorded measurements were submitted to Caltrans QA Lead Inspector, Mr. Alfredo Acuna for records and future reference. Following digital pictures illustrates the u-rib assembly deck plate and recorded dimensions.

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Summary of Conversations:

ABF representative, Mr. David Williams was present at shop where the OBG U-Rib Trial Assembly welding was performed. Mr. Williams informed Caltrans QA Inspector that ZPMC has elected to reject this trial assembly for welding problems encountered during the welding of the u-ribs and ABF concurred with ZPMC. Mr. Williams also stated that ZPMC will formally request an approval from Caltrans to perform another u-rib trial assembly.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer