

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000845**Date Inspected:** 10-Nov-2007**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:** Changxing Island

CWI Name:	Fu Guo Gan	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:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the dimensional testing of Orthotropic Box Girder (OBG) 13 Meter Mock-up closed rib trial # 3, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars witnessed ZPMC QC performing bevel face angle and root face measurements of Closed Ribs for weld trial # 3.

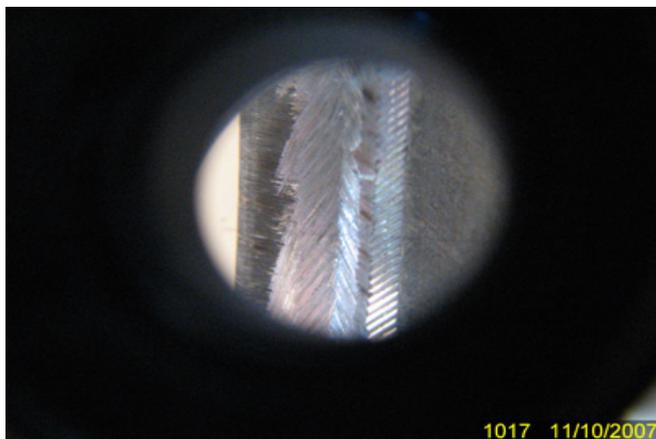
Caltrans QA Inspector performed dimensional measurements of closed rib weld bevel land of 13 meter mock-up closed ribs # U01, U02, U03, U04 and U05. Measurements were taken starting at the left end (hand hole) side random verification measurements taken at each rib. Random measurements were taken by Caltrans after the land had been reworked to remove machining gouges. The recorded dimensions ranged from 1.5 mm to 2.1 mm. Please see the attached photo of the root face as viewed from the optical comparator.

Caltrans QA Inspector observed ZPMC personnel cutting floor beam plate X22A and X22B on Computer Numerically Controlled (CNC) burn table located on in bay # 2. ZPMC QC technicians were noted transferring plate identification numbers after cutting operations.

Caltrans QA Inspector observed that dimensional testing and thermal cutting operations appeared to be in general conformance with AWS D1.5 2002 requirements.

WELDING INSPECTION REPORT

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

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
