

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000889**Date Inspected:** 25-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:** Frank Han**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 & 89 Mock-up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Magnetic Particle testing (MT) of 89 meter mock-up and welding operations of Orthotropic Box Girder, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars was notified by ZPMC QC Mr. Zhang Jiadi upon arrival that Ultrasonic Testing (UT) was to be performed on OBG H shapes in bay # 3. When the QA Inspector arrived the Ultrasonic Testing was completed by ZPMC personnel. ZPMC QC Mr. Li Liming informed the Caltrans QA that 25% of welds BP-006-01-007 (flange), BP-006-01-007 (Web), BP-004-01-020 (Web), BP-004-01-002 (flange) were tested. Mr. Liming found these welds to be acceptable to AWS D1.5 requirements.

Caltrans QA Inspector Viars observed Submerged Arc Welding (SAW) of OBG Side Plate 001 63A to 63B splice weld. ZPMC certified welder Mr. Wu Zhi Bin appeared to be performing the welding in accordance to WPS-B-T-2221-B-L2C-S-1. Caltrans QA Inspector Viars recorded the following welding parameters, amperage 515, voltage of 31, travel speed of 375 with a heat input of 2.55 kJ/mm.

Caltrans QA Inspector Viars witnessed ZPMC QC Mr. Cai Xin Xin performing MT on 89 Meter Mock-up Skin Plate C welds # 13 and 14 root pass. Mr. Cai found these welds to be acceptable. Caltrans QA Viars performed random inspection of the above mentioned welds. Please see attached photo below of Mr. Xin Xin performing MT of Skin plate C.

The Caltrans QA Inspector performed Magnetic Particle examinations of 89 Meter Mock-up Skin Plate C. Caltrans

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QA Inspector observed that the MT and welding appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.



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
