

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-000904**Date Inspected:** 19-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:** Art Peterson**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 Deck Plate Trial**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe testing of Orthotropic Box Girder (OBG) Deck Plate Panel Mock-up Trial, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector witnessed ZPMC QC technicians perform Magnetic Particle Testing (MT) of OBG diaphragm plate to closed rib welds. The area covered by the test was the end of each weld to 50 mm on each side. Please see the attached photo below of the MT performed by Mr. Dongyun. ZPMC QC Mr. Zhou Dongyun performed MT on 100% of the area mentioned above. Caltrans QA Inspector Viars performed random MT of the above mentioned areas.

Caltrans QA Inspector Viars observed ZPMC attempt to perform a pneumatic leak test on the OBG Deck Plate Panel weld trial of the 13 meter U-rib U-01. The rib was pressurized to 0.2 Bar. As soon as the test started a fitting for the pressure gauge was found leaking. ZPMC personnel stated, the test would be performed at 1330. Caltrans QA Inspector Viars returned at 1330 and found that U-rib # U-02 was pressurized and was informed by ZPMC personnel that the leak tested started at 1318.

Caltrans QA Inspector monitored welding Magnetic Particle testing and observed a portion of the leak test. See MT report TL 6038, generated on this date for further information.

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.

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