

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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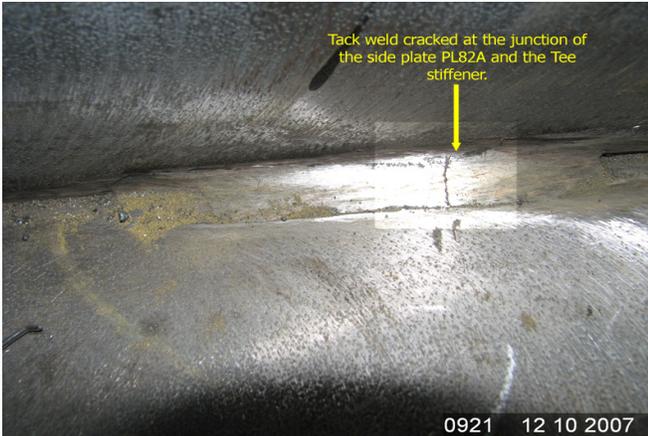
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001017**Date Inspected:** 10-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Jian Ping**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:** Tower Mock-up and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item Description	WBS	Dwg No.	Status
1 OBG Tee stiffeners			
<p>The QA inspector had a conversation with Lead Inspector Lee Chan Woo about occasional flame notches found at the edges of the split W shapes after oxyfuel gas cutting operations, and oil by the weld area at the junction of the plate PL-33 A and the Tee stiffeners. The QA Inspector asked Mr. Lee Chan Woo what were the correcting actions that ZPMC took after oil was found at the weld area when performing fit-up operations on 12/08/2007. Mr. Lee Chan Woo confirmed to the QA inspector the tack weld in question was removed and rewelded again. Mr. Lee Chan Woo also said that ZPMC performed magnetic particle testing to the tack weld area.</p> <p>The QA inspector relayed to Mr. Lee Chan Woo that occasional notches needed to be repaired as per contract documents. The QA inspector expressed his concern about flame notches being repair as per contract documents. Mr. Lee Chan Woo relayed to the QA inspector that ZPMC was complying with the contract documents.</p>			
2 OBG Floor Beam Crack on the Tack Welding			
<p>The QA inspector was informed by Mr. Lee Chan Woo that a tack weld cracked at the Plate PL-87A at the weld joint SP035-01-08, right end second tack weld. See photograph below.</p>			

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3 Bending Plates X6A and X5C

The QA inspector observed ZPMC 8 bent plates, (4)X6A and (4)X5C. The QA inspector asked ABF representatives Kevin Dye and David LeRue why the edges of the plates were not ground with 2 mm radius before cold bending. After asking ZPMC representatives, Mr. David LaRue relayed that the plates were hot bent. Mr. David LaRue relayed that he requested ZPMC to perform MT verification at the edges of the bent areas.

4 OBG Weld Trial test sampling

The QA inspector recorded and marked with Caltrans representatives Pat Lowry, David McClary and John Tracy the test sample areas to be cut for macroetch and mechanical test at the weld # 1 and # 2 from the weld trial after splitting the U-rib in two parts. Caltrans representatives marked 107 locations to be tested.



5 OBG Mock-up deck panel

No fabrication activities were performed on Bay # 1 on the OBG Mock-up deck panel on this date.

Summary of Conversations:

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

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Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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