

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-001018**Date Inspected:** 12-Dec-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:** Shanghai, China**CWI Name:** Fu Yu Hong**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 89 M**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
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1 Tower Mock-up 89 M Ultrasonic testing (UT) Skin E			
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The QA performed UT evaluation from side A & B at the junction of the skin plate E to the longitudinal stiffeners mp543 and mp544 weld joint # 9 and 10. The evaluation of the middle half and bottom quarter was performed with the 70° angle wedge and the top quarter with 45° angle wedge transducer. Also, the QA inspector evaluated from the side C the joint # 9 and 10 with the 45° angle wedge. The QA inspector performed approximately 10 % UT verifications on at the Y location marks from 900 mm to 1100 mm to weld joint # 9 and from 600 mm to 800 mm to weld joint # 10. The QA inspector found that the weld areas tested appeared to be in general compliance with AWS D1.5 2002. See UT report TL_6027 generated on this date.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

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.

WELDING INSPECTION REPORT

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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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