

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-001076**Date Inspected:** 04-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:** Mr. Sha Zhi**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 Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Tower Mock Up:

Bay 2:

The Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel removing scaffolding from 114 M elevation tower mockup assembly. This tower mockup has been tack welded together, and final welding has not been started. Per discussion with American Bridge/Fluor Enterprises, joint venture (ABF) fabrication supervisor Mr. John Hamer, ZPMC Quality Control personnel will perform weld joint inspections as detailed in the "Dimensional Control Plan" hold point step #7 reference drawing FP-MUA-24 after the 114 M tower mockup assembly dimensions are verified using a tower mockup jig. Below is a photograph showing the tower mockup dimensional jig being positioned along side the 114M tower mockup assembly.

The QA Inspector performed random magnetic particle inspections of the skin sub assembly MA-22, 89M face D longitudinal stiffener Partial Joint Penetration (PJP) welds 13 and 14. These welds had previously been magnetic particle inspected and accepted by ZPMC Quality Control personnel. Items observed appear to comply with project specifications.

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The QA Inspector observed ZPMC welder Mr. Zhang Zxang Rong using welding procedure specification WPS-B-T-2332-TC-P5-F to weld the partial penetration groove welds of skin sub assembly MA-22, 89M face D longitudinal stiffener Partial Joint Penetration (PJP) welds 13 and 14 in the in the 2G (horizontal) position. The QA Inspector observed a welding current of approximately 290 amps and 30.2 volts. Items observed by the QA Inspector appear to comply with project specifications.



Summary of Conversations:

See above for today's conversations.

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: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer