

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-001128**Date Inspected:** 29-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:	Ye Yong Jun	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, 77 & 89	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe welding operations and perform visual observations of the Orthotropic Box Girder (OBG) fabrication and of the 89.00 meter mock-up, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars observed ZPMC personnel removing run off tabs for the OBG deck plate trial splice weld # MU1-1-11. The QA inspector observed that Ultrasonic, Magnetic Particle and Radiographic Testing was completed prior to the removal of the run off tabs. Warpage of the deck plate was noted on the 1.7 meter section of the deck trial at U-rib u-06 and U-07. Caltrans QA Inspector Viars was informed by American Bridge Flour representative Mr. Art Peterson that the deck plate was out of tolerance on flatness dimensions and that a heat straightening request would be forthcoming to Caltrans Engineering. Mr. Peterson stated that Nondestructive Testing would be performed again on the deck plate splice weld once the heat straightening request was approved. Please see the attached photo of the run off tab removal of Deck plate trial.

Caltrans QA Inspector Viars observed ZPMC welder Mr. Lei Li Chao performing Flux Cored Arc Welding (FCAW) in accordance with Welding Procedure Specification (WPS) WPS-B-T-2231-TC-U5-F Complete Joint Penetration (CJP) and WPS-B-T-2231-TC-U5-F Partial Joint Penetration (PJP) on 89.00 Meter Mock-up Face "A" sub assembly MA21 welds # 8 and 20 (PJP) weld # 12 (CJP). The following parameters were recorded by Caltrans QA Inspector Viars, amperage 302, voltage 31.5, travel speed 280 with a heat input of 2.03 kJ/mm.

Caltrans QA Inspector monitored welding activities and random visual inspection of the above mentioned items.

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.

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