

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-001148**Date Inspected:** 28-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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 Deck Plate Trial**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform visual observations of Orthotropic Box Girder (OBG) Deck Plate 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 performed visual observations of the Orthotropic Box Girders (OBG) deck plate trial diaphragm welds. The following areas of undercut were noted on diaphragm # 2, U rib 01 right end far side 1.5 mm deep and 13 mm in length, U rib 02 left end far side 1.5 mm in depth and 50 mm in length, U rib 05 left end near side – 1.5 mm deep and 20 mm in length. Undercut measuring 1.5 in deep and 5 mm and length was found on the horizontal weld of diaphragm # 3 between U ribs 3 and 4 at the weld to deck plate toe. Please see the attached photos below of the undercut areas.

Caltrans QA Inspector performed visual observations of the OBG Deck Plate Trial.

