

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-001149**Date Inspected:** 29-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:** 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 dimensional measurements 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 recorded dimensional measurements for weld size on of the Orthotropic Box Girder (OBG) deck plate trial U-rib reinforcement fillet welds. Dimensions greater than 5 millimeter (mm) or less than 2 mm were recorded. The Y axis for reporting purposes is located on the left end of U-01 and U-06 while facing the panel.

The 1.75 meter section of the deck plate panel had a cumulative length of 1012 mm of oversized and undersized welds. The maximum reinforcement found was 7.5 mm and a minimum of 1 mm. An undersized area measuring 420 mm in length and 1 mm reinforcement was located on U-06 from 1170 to 1590 mm.

The 13 meter section of the deck plate had a cumulative length of 6656 mm of oversized and undersized welds. The maximum reinforcement found was 10 mm and a minimum of 1 mm. An oversized area measuring 52 mm in length and 10 mm of reinforcement was located on U-rib U-03 from 9262 to 9314. A total of 2563 mm of undersized and oversized welding was found on U-rib U-04 weld 7.

The above mentioned welding reinforcement does not appear to meet the tolerances specified in the contract drawings.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations occurred on this day.

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:	Carreon,Albert	QA Reviewer
