

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001176**Date Inspected:** 07-Jan-2008**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:** Xu Bing**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:** CT Mock-up, OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe welding operations of the Orthotropic Box Girder (OBG). The 77.00, 89.00 and 114.00 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 welder Mr. Sun Tiyu tack welding OBG side plate T stiffener weld SP-054-01-027 and 28 to the specifications of WPS-B-T-2132-2.

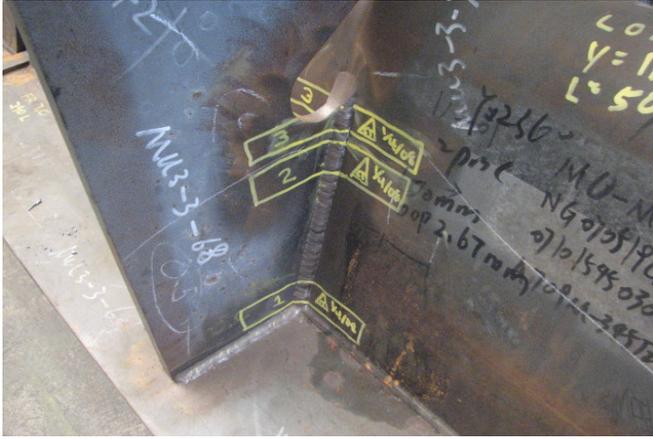
Caltrans QA Inspector Viars observed ZPMC Welder Mr. Fu Yanjie performing Shielded metal Arc Welding (SMAW) of Mock-up 77.00 welds 45 and 46 (SA104) diaphragm to stiffener. ZPMC was noting performing SMAW on 77.00 welds 45 and 46 (SA95). Welding was performed in accordance to WPS-B-T-4313-TC-P4-1.

Areas that were marked for Macroetch samples on the OBG Deck Plate Trial 1/4/08 had not been removed as of 1/7/08. Areas not removed were as follows, 1.7 meter to 13 meter panel splice weld (6), closed rib to diaphragm (9), diaphragm to deck plate (3) diaphragm to flange (3). A total of 21 areas have not been removed. Please see the photo below of a closed rib to diaphragm macroetch location.

Caltrans QA Inspector observed that welding appeared to be in conformance with AWS D1.5 requirements.

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
