

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-001191**Date Inspected:** 07-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:** Shanghai, China**CWI Name:** Fu Yu Hong**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**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

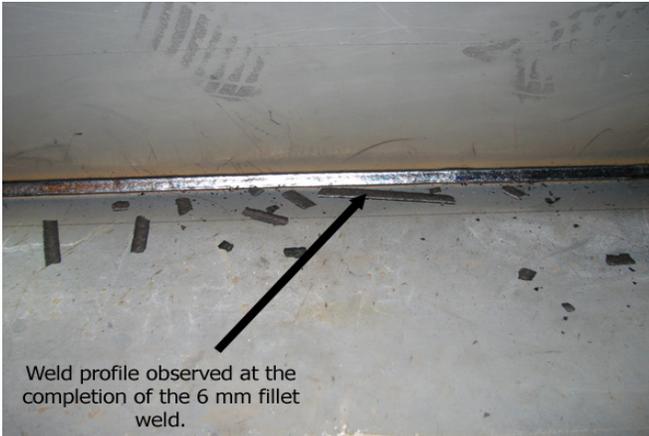
Item Description	WBS	Dwg No.	Status
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1	OBG Welding operations at the WT to Bottom plate PL-42 Panel BP-12		
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The QA inspector performed welding operations at the junction of the Bottom plate PL-42 to the WT shapes (6 mm fillet) following the approved welding procedure specification WPS-B-F-2132-2. Base metal was designated as A-709 Grade 50. ZPMC was using the flux cored arc welding (FCAW) process in the horizontal (2F) position with the 1.4 mm diameter electrode designated as E71T-1 /AWS A5.20, brand name Supercored at the weld joints BP-012-01-024 thru BP-012-01-013. The QA Inspector verified amperage, voltage, travel speed, preheat and heat interpass temperatures. The QA inspector found that the welding parameters appeared to be in accordance with the contract documents.

WELDING INSPECTION REPORT

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Weld profile observed at the completion of the 6 mm fillet weld.



ZPMC was performing welding operation at the ribs # RS9Ds to deck panel PL42-A

3 OBG Fabrication Activities

The QA inspector performed observation of ZPMC's fabrication:

1. Drilling operations on the WT stiffeners designated as RS110 for the PL96A.
2. Fit-up of the side Plate PL-102A, panel SP-65 WT stiffeners.
3. Fit-up of the bottom Plate PL-40, panel BP-9 WT stiffeners.
4. Fit-up of the bottom plate PL-39, panel BP-8 WT stiffeners.

The QA inspector observed that the fabrication activities appeared to be in general compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

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: Acuna, Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer