

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-001212**Date Inspected:** 26-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:** Shanghai, China**CWI Name:** Lu Jian Hua**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 and Tower Mock-up**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 |
|--|-----|---------|--------|
| 1 UT verifications on the floor beams subassembly The QA inspector performed 10 % ultrasonic testing (UT) verifications at the weld joints FB-015-01-02 and FB-002-03-023 at the floor beam subassembly. The QA inspector discovered that the weld areas tested appeared to be in general compliance with AWS D1.5 2002. See UT report TL_6027 generated on this date. | | | |
| 2 114 M Tower Mock-up Lower Section skin A & B and B & C. The QA inspector witnessed the ZPMC's UT verifications at the corner joint connections at the skin plate A and B, and B and C at the end of the shift (the QA inspector witnessed the start of ZPMC's UT evaluations). The QA observed that ZPMC was scanning a 90 mm plate (sound path for the bottom quarter of approximately 263 mm with the 70 degrees transducer and wedge) with a 24 dB over the reference level in lieu of 45 dB as per table 6.3 AWS D1.5 (2002). The QA inspector brought to the attention of ABF representative Mr. David LaRue. The QA inspector added that the QA inspector had mentioned this issue to ABF in numerous occasions. Mr. David LaRue agreed that ZPMC needed to scan per contract documents. Later, ABF representative said that he was going to generate an incident report about this matter and ABF was going to have a meeting with ZPMC in regarding to issue. | | | |
| 3 UT verifications to the Corner connections plates SA-42. The QA inspector performed 10 % Ultrasonic testing (UT) verifications at the corner weld joint # 10 at the shear link corner connection plate for subassembly SA-42. The QA inspector found that the weld areas tested appeared to be in | | | |

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general compliance with AWS D1.5 2002. See UT report TL_6027 generated on this date.

Summary of Conversations:

As noted above.

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.

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| Inspected By: | Acuna,Alfredo | Quality Assurance Inspector |
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| Reviewed By: | Cuellar,Robert | QA Reviewer |
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