

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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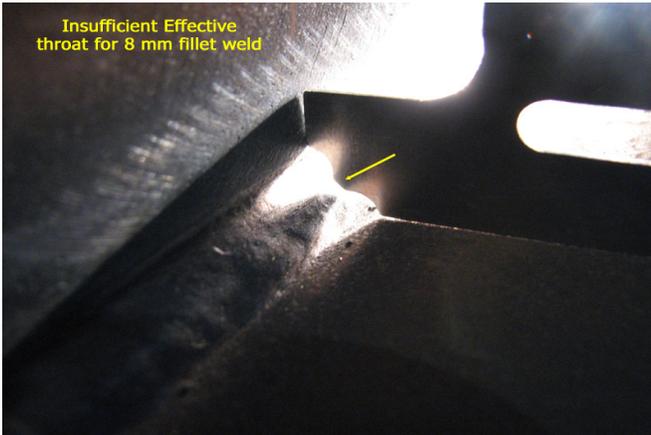
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001232**Date Inspected:** 25-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime 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:** 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
1 OBG ZPMC Magnetic Particle Testing (MT) The QA inspector witnessed ZPMC Cai Xin Xin performing 10 % MT verifications at the junction of the WT to the side plates for panels SP-069 and SP-057. The QA inspector observed that ZPMC's MT verifications appeared to be in compliance with the contract documents.			
2 Visual and MT verifications to Side Panels OBG The QA inspector performed 100 % visual weld inspection and 10% magnetic particle testing (MT) at the junction of open ribs stiffeners and side plate panels SP-26 and SP-22. The QA inspector observed that welds appeared to be in compliance with contract documents. The QA inspector started the visual weld inspection to the side plates SP030 at the junction of the WT stiffeners to side plate weld joint 013, when the QA inspector observed undersized fillet weld at approximately the entire length of the weld (effective throat and leg size), See photograph below. The fillet weld size required was 8 mm. The QA inspector stopped and brought to the attention of ZPMC QC representatives Mr. Zhang Jiadi (Ken) and Fu Yu Hong that the weld was undersized on the entire length at the panel SP030 weld joint 013 and ZPMC needed to perform visual weld inspection again after rewelded to the entire weld before call Caltrans QA inspectors for visual weld inspection. ZPMC agreed that the weld was undersized and informed to the QA inspector that ZPMC would weld another pass on the Gantry machine as required.			

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3 FCAW Welding operations on the Gantry OBG Side plates

The QA inspector observed ZPMC welding operators Xin Meng, Li Shu Liang and Li Zhao Quian performing welding operations at the Gantry machine with the flux cored arc welding (FCAW) process in the horizontal (2F) position following the welding procedure specification (WPS) WPS-B-T-2132-3. The QA inspector performed random verifications of the welding parameters. The QA inspector observed ZPMC performing welding operations as follows: Mr. Xin Meng at the joints BP-003-01-012 and 013; Mr. Li Shu Liang at the weld joints BP-003-01-017 and 018 and Mr. Li Zhao Quian at the weld joints BP-003-01-008 and 009. The QA inspector observed that the welding operations appeared to be in accordance with the contract documents.

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.

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