

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-001235**Date Inspected:** 04-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:** 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 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 OBG UT Deck Mock-up PJP			
The QA inspector performed ultrasonic testing (UT) verifications at partial penetration joint (PJP) at the junction of the deck mock-up to U-ribs by the areas where ZPMC was going to remove the macroetch test samples selected by Caltrans.			
The QA inspector found the following results:			
Macroetch Test Samples #			
1A1 UT no LOP recorded from Y location 0 to 200 mm			
1A2 UT no LOP recorded between Y location 5130 and 5720 mm			
1A3 UT no LOP recorded between Y location 8000 and 8700 mm			
2A1 UT no LOP recorded between Y location 0 and 210 mm			
3A1 UT no LOP recorded between Y location 0 and 200 mm			
3B1 UT LOP recorded at Y location 24 mm LOP= 2.54 with 15 mm of length. The QA inspector verified between Y location 0 and 420 mm.			
4A1 LOP recorded at Y location 52 mm LOP= 2.54 with 15 mm of length. The QA inspector verified between Y location 0 and 380 mm.			
4B1 no LOP recorded in between Y location 0 and 410 mm			
5A1 no LOP recorded in between Y location 0 and 410 mm			

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5B1 UT LOP recorded at Y location 550 mm LOP= 2.81 with 75 mm of length. The QA inspector verified between Y location 0 and 740 mm.

5B2 UT LOP recorded at Y location 5840 mm LOP= 2.72 with 75 mm of length. The QA inspector verified in between Y locations 0 and 740 mm.

ZPMC did not identify the above mentioned areas per ZPMC's PJP UT procedure(revision # 6).

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
