

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-001350**Date Inspected:** 23-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** CXhangxing Island**CWI Name:** Wu Mingkai**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:**

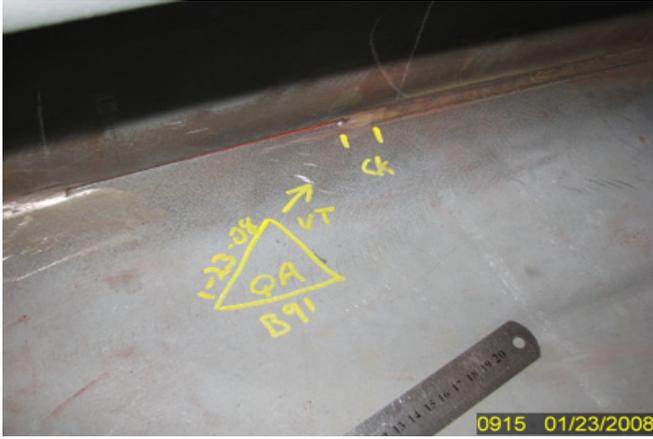
Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual Testing (VT) and Magnetic Particle Testing (MT) of the Orthotropic Box Girder (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars performed random visual observations of Side Plate SP074 WT stiffener fillet welds. ZPMC had performed VT and MT of the fillet welds. The Side plate had not been turned over to Caltrans for VT and MT inspection. QA inspector Viars found a crater crack (linear) on weld joint # SP074-01-002. The crack was intermittent and totaled 10mm within an 18mm area. The linear crack was shown to ZPMC QC Mr. Shen Xue Jun. Mr. Shen requested ZPMC QC Mr. Cai Xin Xin perform an additional 20% MT of the weld joint. The crater crack was located outside of 10% of weld length originally inspected with Magnetic Particle Testing. No additional indications were found within the 20%. Mr. Shen stated that a Critical Weld Repair would be submitted for approval for the 10 mm crack. Please see the attached photos of the linear crater crack mentioned above.

Caltrans QA Inspector Viars was informed by Mr. Shen Xue Jun that Side Plate SP035 fillet welds had been visual accepted and 10% MT performed by ZPMC personnel and was ready for QA verification. Please see MT report TL-6028 generated on the is date for further information.

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
