

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-001388**Date Inspected:** 11-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	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:	NA	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

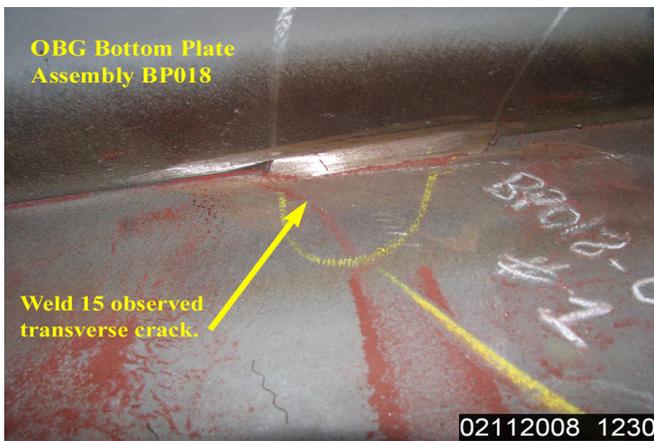
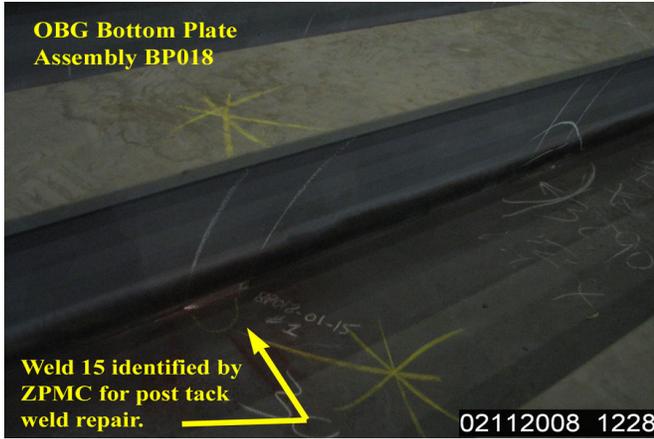
ZPMC stated that no work would be performed on the Caltrans Project tonight. No ZPMC personnel observed working on the Caltrans Project.

Item Description	WBS	Dwg No.	Status
1 OBG Bottom Plate	NA	NA	NA

Caltrans QA Inspector observed tack welds on bottom plate (BP018) assembly in Bay 3 have been magnetic particle tested and marked up for post tack weld pick-ups by ZPMC. The assembly is mounted on the welding gantry table; fasten down in the precamber position with C-clamps. The assembly is approximately 10 meters long with six split tees tack welded to the plate. The tees will be joined to the bottom plate, full length, 10 mm (millimeter) fillet weld, both sides. Caltrans QA Inspector observed that the tack welds joining the tees to the bottom plate have been magnetic particle tested by ZPMC. It appears that approximately twenty-four tack welds have been marked up for post tack weld repairs. Caltrans QA Inspector visually inspected several of the identified locations for repair. It appeared that many of the locations had transverse crack indications. The following digital pictures illustrate the bottom plate assembly and a typical transverse weld crack indications observed.

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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: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer
