

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-001414**Date Inspected:** 28-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

Bay 3

QA Inspector observed ZPMC welder Ms. He Yu Mei stencil 48625 is using welding procedure specification WPS-B-T-2132-2 using the flux cored welding process for fillet tack welds on OBG PL85A side plate SP001 stiffener plate welds SP001-01-017 and SP001-01-018. The QA Inspector observed a welding current of approximately 280 amps, 28.6 volts and the base material has a minimum preheat temperature of 100° C. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC personnel using a heavy weight to apply a downward force on side plate SP024 as it is positioned into a "U" shaped camber fixture. See the photographs below for additional information.

Bay 7

The QA Inspector performed dimensional inspections of Floor Beam plates detail "WT1" typical weld

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terminations. All “X” and “Y” measurements are being compiled on a spreadsheet that is to be submitted to Caltrans Engineering for evaluation.

During this shift, the QA Inspector observed no ZPMC personnel performing welding in bay 7.



Summary of Conversations:

See above for summary of conversations.

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: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
