

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-001462**Date Inspected:** 15-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:	See Below	

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.

Item Description	WBS	Dwg No.	Status
1 PMT	NA	NA	See Below

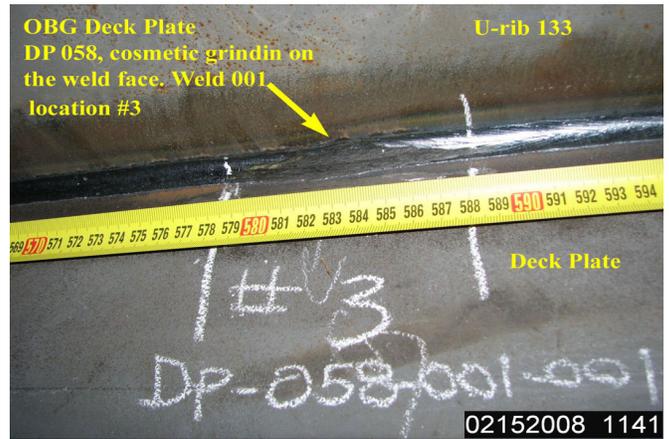
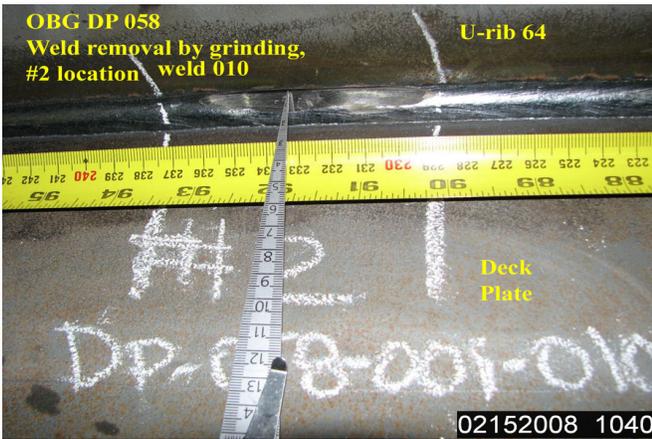
OBG Bay 1: Caltrans QA Inspector performed Visual Test (VT) examination on the welds for Production Monitoring Test (PMT) for deck plate DP 58. Caltrans QA Inspector witnessed ZPMC Quality Control Inspector, Mr. Fu Yu hong identify locations for test specimen removal, for specimen #1, 2 and 3, in accordance with Caltrans Special Provisions requirements. Caltrans QA Inspector identified locations for test specimens 4 and 5. The specimen locations were marked with a paint stick for future removal. The following digital picture illustrates the identification marking of the 6 test specimens.

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- 2 Deck Plate Assembly NA NA See Below
- OBG Bay 1: Caltrans QA observed ZPMC shop worker grinding on completed welds and removing weld material for future welding repair, on Deck Plate DP 058 assembly. Caltrans QA Inspector met with Mr. Fu Yu Hong and informed him that ZPMC has not an approved welding procedure. Mr. Fu Yu Hong was with understanding that ZPMC does not have to have an approved welding procedure for this type of weld repair. After several conversations with Caltrans Task Leaders, Mr. Jimmy Cochran and Mr. David Mc Clary, Mr. Fu Yu Hong decided to have the repair grinding stopped. See Caltrans Quality Assurance- Incident Report (TL-15) for this date for further information. The following digital pictures illustrate typical weld removal grinding locations.



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

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Reviewed By: Cuellar,Robert

QA Reviewer