

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-001520**Date Inspected:** 08-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island

CWI Name:	Wu Ming Kai	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 observations and monitor welding operations 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 Quality Assurance Inspector observed ZPMC personnel drilling bolt holes with a template for OBG closed ribs, U182, U183, U184, and U194 in bay # 1. Bolt holes appeared to be in conformance with contract drawings.

Caltrans QA Inspector observed ZPMC welder Mr. Pan Ben Yang performing Flux Cored Arc Welding (FCAW) in the 1G position on Deck Plate 052 PL112B to 112B splice weld. Welding appeared to be in conformance with WPS-B-T-2221-B-L2c-S-1.

Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of Side Plate 030/PL84A located in Bay # 3. ZPMC personnel performed 100% MT of the SP030 fillet welds after transverse cracking was discovered by Caltrans representatives. Caltrans QA performed MT of welds SP030-01-013 thru SP030-01-020 and was in agreement with ZPMC QC Magnetic Particle Testing test results of 20 transverse indications in SP030 WT stiffener fillet welds.

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

WELDING INSPECTION REPORT

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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
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Reviewed By:	Cuellar,Robert	QA Reviewer
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