

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-001624**Date Inspected:** 02-Mar-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:** Sha Zhi**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:** 89M Mock-Up**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 the orthotropic box girders, 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 Strut Subassembly	NA	NA	Welding in progress

New Tower Shop 89M Mock-Up: Caltrans QA Inspector observed ZPMC performing shielded metal arc welding (SMAW) at 89M Mock-Up, strut subassembly. The welder is identified as Mr. Dai Lu, welder #048659, welding weld repair WR077, weld MUSB-MA26-30A, WPS-485-SMAW-2G. Caltrans QA observed ZPMC Quality Control (QC) certified welding inspector (CWI), Mr. Sha Zhi monitoring and recording welding parameters. Caltrans QA observed that the weld repair excavation area was ground to bright metal prior to welding. The following digital picture illustrates welding in progress.

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- 2 Tower Diaphragm Plate NA NA Heat Straightening
Bay 8: Caltrans QA observed ZPMC shop personnel performing heat straightening two tower diaphragm plates, P921 (E) 1 and SA 293 (S) 38M BTM. Caltrans QA met with the CWI inspector, Mr. Yu Dong Jin, monitoring the heat straightening activities at the work-station. Mr. Yu Dong Jin stated, heat straightening for diaphragm plate P921 (E) 1 is being performed in accordance with ZPMC procedure HSRI-(T)-063, Revision 0 and SA 293 (S) 38M BTM in accordance with HSRI-(T)-052, Revision 0. Caltrans QA reviewed the heat straightening procedure and work being performed was found to be in accordance with the procedures. The following digital picture illustrates heat straightening of diaphragm plate P921 (E) 1.



- 3 89M Mock-Up NA NA ZPMC MT
New Tower Shop 89M Mock-Up: Caltrans QA was notified by ZPMC QC that ZPMC would be performing magnetic particle (MT) on the root pass welds identified as MUB-MA21 J/J- 6 and 7. Caltrans QA witnessed QC inspector, Mr. Zhu Dong Yun perform the MT testing of welds 6 and 7. Caltrans observed that the QC MT coverage was 100% and performed in conformance with the contract specifications. Caltrans QA performed MT/QA verification of welds 6 and 7. See Caltrans Magnetic Particle Test Report (TL-6028), generated on this date for additional information.

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

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for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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