

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-001649**Date Inspected:** 05-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**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:** 77 Mock-up and OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Magnetic Particle Testing (MT) of the 77 meter tower mock-up, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector performed MT verification of the 77 meter Mock-up Partial Joint Penetration (PJP) and fillet welds associated with diaphragm plates SA95 and SA104. ZPMC QC Mr. Zhou Dongyun and Mr. Cai Xin Xin performed MT of 5 welds that were found unacceptable by Caltrans QA on 3-03-2008. Mr. Dongyun accepted 3 of the welds previously found unacceptable. Caltrans QA Inspector retested the welds and found the same indications that were reported on the 3-03-2008 were still present. An incident report was issued on this date for QC oversight. Please see MT report TL-6028, generated on this date for further information. The following picture below illustrates indications overlooked by ZPMC QC.

Caltrans QA inspector observed ZPMC welder Mr. Liu Xiaomin performing Gas Metal Arc Welding (GMAW) of Deck Panel DP026-002 U-rib tack welds. The following welding variables were recorded, amperage 333, voltage 30.2, travel speed 541 with a heat input of 1.11 kg/mm. Welding appeared to be in conformance with WPS-B-T-2342-U2 (u-rib).

WELDING INSPECTION REPORT

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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:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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