

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-001651**Date Inspected:** 01-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:	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 SP and BP	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual Testing (VT) and Magnetic Particle Testing (MT) 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 QA Inspector Viars performed MT verification of the following OBG side plates, SP045 welds SP045-016 through 029, SP045 welds SP045-01-030 through 043, SP057 welds SP057-01-025 through 036 and SP070 welds SP070-01-001 through 012.

Caltrans QA Inspector for witnessed ZPMC QC Cai Xin Xin performing MT of bottom plate base metal excavation areas for BP022 and BP023. Testing was required per critical weld repair CWR 31 (BP023) and CWR 32 (BP022). Mr. Cai relayed that the excavation areas were acceptable. Caltrans QA inspector performed MT verification of the excavation areas. Upon completion of MT ZPMC welder Xiao Feng performed Shielded Metal Arc Welding (SMAW) of the excavation areas. The following welding variables were recorded, amperage 191, voltage 22 (ZPMC), travel speed 116 mm/min. with a heat input of 2.17 kJ/mm. Welding operations appeared to be in conformance with WPS-345-SMAW-2G (2F)-FCM.

Please see the MT report TL-6028, generated on this date for further information.

Summary of Conversations:

As identified within the contents of this report.

Comments

WELDING INSPECTION REPORT

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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
Reviewed By:	Cuellar,Robert	QA Reviewer
