

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001671**Date Inspected:** 26-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei & Chen Xi**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:**

This Quality Assurance Inspector (QAI) observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

Orthotropic Box Girder (OBG)

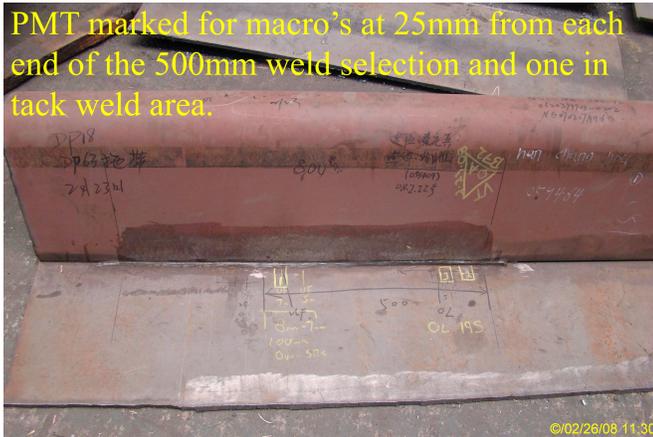
In Bay 1 this QAI observed the milling of plate edges, beveling of partial joint penetration (PJP) preparations, machining of 2 millimeter radius on edges of plates and drilling of bolt holes using hardened washer guides of un-bent closed u-rib plates. This QA Inspector also witnessed the simultaneous bending of the close u-rib panels in compliance with the special provisions. Welding was also being carried out on the panels inside of the bent closes u-ribs. Gas metal arc welding (GMAW) of the root and submerged arc welding (SAW) final weld passes were also being made to the production mock up test (PMT) and closed u-rib to deck plate welds.

This QAI completed final visual inspection of deck panel DP018-001 weld joints 006 & 007 and completed the Visual Inspection Report for the OBG Deck Panels spreadsheet. This completed inspection of the panel and a copy of the spread sheet was given to the Island Structural Materials Representative Mr. Ady Velasco.

This QAI witnessed fillet welding with the flux core arc welding (FCAW) process between the closed u-rib U59 and panel by ZPMC welder Zhau Cheng Shuang, welder identification 059400. The weld joint number was DP030-001-030. Some of the essential welding variables were checked and recoded as follows: voltage 25.3, amperage 20 and travel speed 105 millimeters per minute in accordance with WPS-B-T-2234-B-U2.

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Summary of Conversations:

No conversations held today.

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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
