

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-001739**Date Inspected:** 14-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**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:** Li Zhi Jiang**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:** Side Plate**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 orthotropic box girders (OBG), 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 Side Plate	NA	NA	Welding and MT

New OBG Building: Caltrans QA Inspector witnessed AB/F inspector, Mr. David La Rue magnetic particle (MT), side plate SP69B, tack welds joining plate splice P104C.(SPCM). The AB/F inspector also MT replacement tack weld at SP8, joining plate splice P69A (SPCM). The welding of the replacement tack weld was performed by welder, identified as Mr. Gu Xueming, welder number 045218. Caltrans QA observed ZPMC QC/CWI, Mr. Li Zhi Jiang monitoring the welding activities. The weld welding procedure specification was identified as WPS-B-P-2211-B-U2, Revision 1. Mr. David LaRue stated that the welding of the plate splice welds was stopped, during the AM shift by AB/F, Mr. Peter Ferguson, until further notice. However, Mr. Ferguson allowed ZPMC to perform fitup and tack welding only. The following digital picture illustrates AB/F MT examination of SP69B tack welds and ZPMC welding the replacement tack weld.

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