

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001812**Date Inspected:** 09-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:****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:**

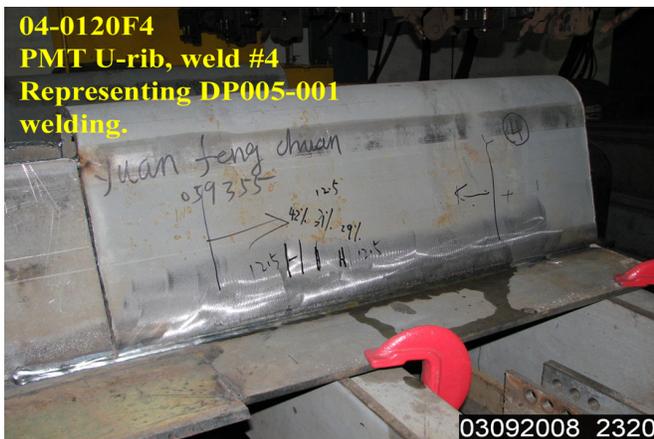
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girders (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 PMT	NA	NA	QA UT Complete

Caltrans QA Inspector performed Ultrasonic Test (UT) inspection on four Production Monitoring Tests (PMT's) for Deck Panel DP005-001. Welding of the PMT's was completed and on 03-09-2008. PMT welds are identified as Weld #1 through #4. QA Inspector found welds 1 and 4 not in compliance with the contract documents, approved plans, fabrications documents and Special Provisions for this project: See Caltrans Ultrasonic Testing Report (TL-6027) Modified dated March 09, 2008 for additional information. The following digital picture illustrates PMT weld #4.

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- 2 Floor Beam Sub Assembly NA NA ZPMC MT in Progress
- ZPMC presented Notification of witness inspection for magnetic particle testing of final weld for floor beam identified as FB004-04, welds 001, 003, 004, 007, 008, 009, 012, 013, 016, 017 and 021 at 1845 hours. Caltrans QA witnessed ZPMC QC perform magnetic particle (MT) on fillet weld, diaphragm plate joining flange plate to web plate. The ZPMC QC inspector is identified as Mr. Zhou Dongyan. Caltrans observed that the QC MT coverage was 100% and performed in conformance with the contract specifications. The following digital picture illustrates ZPMC MT inspection in progress.



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
