

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-001867**Date Inspected:** 23-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:** See Below**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:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

CWI Inspector: Wu Ming Kai

Bay 1

QA Inspector observed ZPMC welder Mr. Sheng Qizhen stencil 59401 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG deck plate closed rib welds DP055-001-007 and DP055-001-008. The QA Inspector observed a welding current of approximately 350 amps and 30.2 volts. Items observed by the QA Inspector appear to comply with project specifications.

QA Inspector observed ZPMC welder Mr. Tang Ke stencil 62305 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG deck plate weld DP055-001-005 and DP055-001-006, closed ribs. The QA Inspector observed a welding current of approximately 350 amps and 29.6 volts. Items observed by the QA Inspector appear to comply with project specifications.

WELDING INSPECTION REPORT

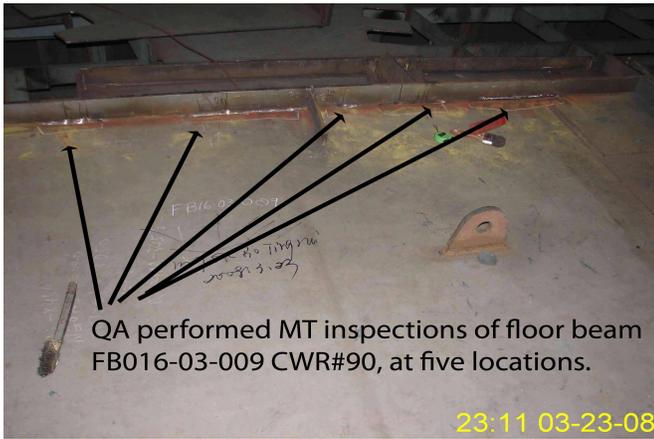
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Bay 2, 3 and 7

QA Inspector observed no ZMPC personnel performing any welding of Caltrans materials in bays 2, 3 or 7.

Bay 7

The QA Inspector performed random visual and magnetic particle inspections of critical weld repair #44 grind areas located in floor beam welds FB015-03-001 (one location), FB015-03-009 (two locations) and FB016-03-009 (five locations). ZPMC QC Inspector Mr. Ro Ting Iui had previously accepted the magnetic particle inspections of these grind areas. Areas that were inspected by the QA Inspector appear to comply with project specifications.



Summary of Conversations:

See above for summary of conversations.

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 Patrick Lowey (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Dawson, Paul

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer