

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-001973**Date Inspected:** 14-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**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:

CWI Inspector: Mr. An Qing Xiang

Orthotropic Box Girder (OBG) and Tower Fabrication:

New tower shop

The QA Inspector observed ZPMC personnel perform heat straightening of plate SA80 (W) to resolve mill induced distortion as directed by HSR1(T)-816. The QA inspector observed Quality Control Inspector Mr. Zhao Mao Mao monitoring the heat temperature and the maximum temperature recorded by Mr. Mao is 586°C. which does not exceed the maximum allowable temperature listed in the HSR document. Items observed appear to comply with project specifications.

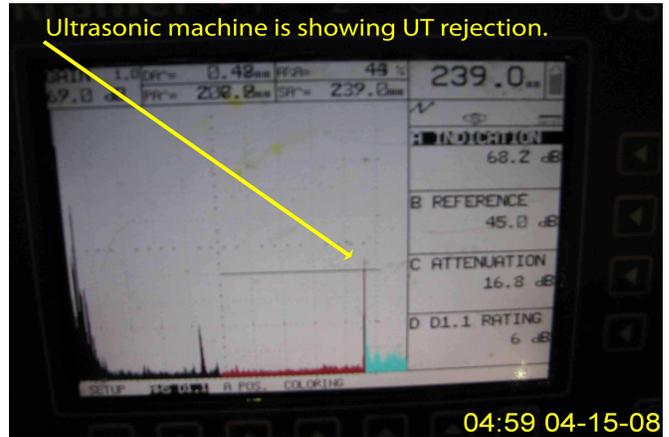
The QA Inspector observed ZPMC welder Mr. Sun Bingfa stencil 62046 is using welding procedure specification WPS-B-T-2221-B-L3C-S to make submerged arc groove weld ESD-SA227 A/H-13B. Prior to the commencement of welding the QA Inspector observed ZPMC QC Inspector Mr. An Qing Xiang inspecting and marking areas of the weld groove, and a second ZPMC employee was grinding the areas that had been marked.

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The QA Inspector observed a welding current of approximately 650 amps, 33.0 volts, a travel speed of 570 mm per hour, and the base material is between 110°C and 230°C. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector performed ultrasonic inspection of complete joint penetration weld ESD-SA227-A/H 16 A/B and this weld appears to have a class "A" UT rejection area located near the top weld crown. See the TL-6027 "Ultrasonic Test Report" dated today and the photographs below for additional information.



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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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