

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-002008**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:****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**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 Tower Plate	NA	NA	ZPMC Heat Straightening

New Tower Shop Bay 2: The Caltrans QA Inspector observed ZPMC performing flame heat straightening operations on tower skin plates for mill induced distortion. The tower skin plate and heat straightening procedure are identified as skin plate P793 (E), procedure HSR1 (T)-681, revision (0). Caltrans QA observed ZPMC heating the plate manually with a rose-bud torch. Caltrans QA observed ZPMC Quality Control Inspector, Mr. Lui Dao feng monitoring the heat straightening of the plate using a calibrated infra-red temperature indicating device to monitor the heat and being witnessed by ABF Inspector, Mr. Mike Williams. The following picture illustrates ZPMC heat straightening tower plate.

WELDING INSPECTION REPORT

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|---|------------------|----|----|------------------------|
| 2 | Tower Skin Plate | NA | NA | Weld Joint Preparation |
|---|------------------|----|----|------------------------|
- New Tower Shop Bay 1: Caltrans QA Inspector observed material prep after backgouging. The subassembly is identified as P375 to P228, plate splice weld, weld joint identification ESD1-SA107 A/J-18B. Caltrans QA observed ZPMC shop worker grinding the backgouge to bright metal and restoring groove profile within dimensions as described in AWS D1.5, Figure 2.5 requirements.

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
