

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-002032**Date Inspected:** 21-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Weiqing, Cui Yi Ru**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 Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.). Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

(Bay 7), The QA Inspector asked the Quality Control (QC) Inspector where the weld number designation was, as it was not written on the piece, the QC Inspector stated that it would be written on it after the weld was completed. The QA Inspector, asked if it wasn't supposed to be there now, after some discussion, the QC Inspector wrote the weld number adjacent to the weld. Z. P. M. C. personnel were back gouging and grinding on weld number Floor Beam (FB)017-02-122, in preparation to it being welded. Welder, Huaing Xin Tan—044780, using Welding Procedure Specification (WPS)-B-T-2221-B-U2C-S-1, started welding a stiffener plate onto FB017-02-122. This is a Submerged Arc Welding (SAW) WPS.

Z. P. M. C. personnel were back gouging the bevel root, it did not have complete weld penetration from the other side, as weld penetration normally observed was not present. It is possible, that it was only tacked to held in place. This is a stiffener plate that will be SAW welded.

The QA inspector went into Bay 7 to inspect some Floor Beams that were on a list (this consisted of a Xerox copy of Post-It notes), that were given to Caltrans QA to inspect. None of the Piece Marks noted on the list were visible.

The QA Inspector was required to stop work abruptly, after Caltrans QA was given a 10 minute notice, that the only transportation off of the Island, would be leaving, within that 10 minutes.

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Summary of Conversations:

No substantial conversations took place.

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:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
