

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-002194**Date Inspected:** 03-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1630**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:	NA	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 Fabrication:

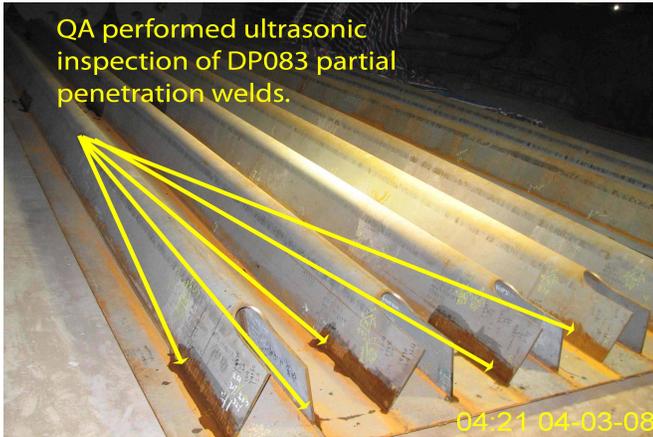
QA Inspector performed ultrasonic inspection of deck plate DP083-001 closed rib partial penetration welds #1 through #6. The purpose of this inspection is to determine if the completed welds have an adequate amount of penetration. The closed ribs have a nominal plate thickness of 12 mm and the partial penetration welds are required to have a minimum of 80 percent penetration ie: 9.6 mm. One of the welds that was inspected today appear to have areas with less than 9.6 mm weld joint penetration and the remaining welds appear to contain an adequate amount of weld penetration.

QA Inspector performed ultrasonic inspection of deck plate DP110-002 closed rib partial penetration welds #1 through #5. The purpose of this inspection is to determine if the completed welds have an adequate amount of penetration. The closed ribs have a nominal plate thickness of 12 mm and the partial penetration welds are required to have a minimum of 80 percent penetration ie: 9.6 mm. Four of the welds that were inspected today appear to have areas with less than 9.6 mm weld joint penetration and the remaining welds appear to contain an adequate amount of weld penetration. The results of this inspection have been documented on QA Ultrasonic Inspection report titled: "04-0120F4_6027MOD_B63_04-03-08_ZPMC_DP110-002". See the photograph below

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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 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
