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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-002253
Date Inspected: 07-May-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 2300
OSM Departure Time: 730
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: OBG Deck Plate

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 Girder (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	U-rib Deck Plate	NA	NA	QA-VT

OBG Bay 1- Caltrans QA Inspector performed a Quality Assurance visual weld inspection on Orthotropic Box Girder (OBG) Deck Panel Assembly identified as DP138-001, partial joint penetration (PJP) welds 001 through 010, joining u-ribs to deck plate. QA Inspector observed various defects which include oversize weld, overlap, underfill, undercut and incomplete fusion. The length and the location of each of these areas were recorded on the Caltrans QA Visual Weld Inspection Report for the Orthotropic Box Girder (OBG) and Deck Panel for tracking and distributed to the appropriate personnel for review. The following digital pictures illustrates deck panel DP138-001 and typical markings, identifying weld indications. The following digital pictures illustrate deck panel.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer