

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-002278**Date Inspected:** 13-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Fu Yu Hong**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 and Tower Skin plates**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed 15 % ultrasonic verifications (UT) on the partial penetration weld (PJP) after ZPMC representative verifications were completed on the deck panel DP-110-001 weld joints 8 and DP-486-001 weld joint 1. The QA inspector concurred with ZPMC on the overall location and sizing of the areas identified with incomplete penetration. Locations with depth of penetration had less than 80 % were reported. See UT report TL_6027 generated on this date.

Tower Skin Plate South Shaft

The QA inspector performed 10 % ultrasonic testing (UT) on the completed joint penetration (CJP) after ZPMC representative verifications at the skin plate ESD1-SA-233AF-20B, ESD1-SA233 A/F 21, SSD1-SA173 A/B-19B, SA-157 F/J-15A and SSD1- SA173-B/K-7B. The QA inspector found that the weld areas tested from side B appeared to be in general compliance with AWS D1.5 2002. See UT report TL_6027 generated on this date.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

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.

WELDING INSPECTION REPORT

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Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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