

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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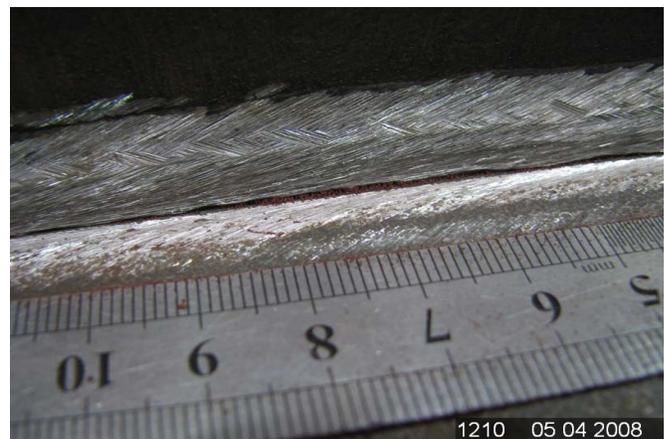
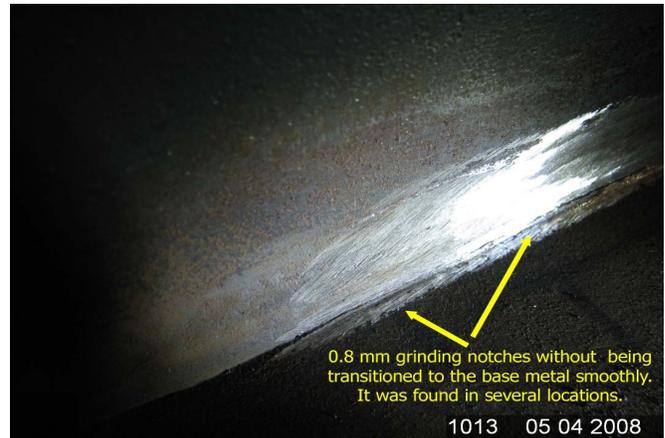
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002281**Date Inspected:** 04-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime 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 Deck panels**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 visual weld inspection to the deck panels DP-059-001 welds 1 thru 8 after ZPMC completed the visual and magnetic particle inspections. The QA inspector found weld discontinuities identified as overlap, undersize welds and notches at the toe of the weld caused by the grinding operations. In addition, the QA inspector performed magnetic particle inspection (MT) and found a flux leakage from the corner from the remaining overlap. The QA inspector had a conversation with ABF representative Warren Buehler. The QA inspector showed the areas in question. ABF agreed, however, Mr. Warren Buehler found 2 mm as fillet weld size with the ZPMC and ABF's bridge cam gages on the areas identified as undersized. The QA inspector compared the gages and the tip of the bridge cam gages from ZPMC and ABF and observed that the tips of the gages were dull and rounder. In this particular case, ZPMC could not measure with accuracy the weld size of the partial penetration weld (inside the cavities present from the weld overlap). Mr. Warren Buehler said that he could not reject the weld as weld undersize because ZPMC and ABF were measuring 2 mm regardless. He added that the weld still was overlapped anyway and need it to be perform additional grinding on the toes of the weld which it was going to lead to weld undersize. ZPMC agreed to repair. See photograph below.

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Summary of Conversations:

As noted above

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.

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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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