

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-002466**Date Inspected:** 03-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chi Meng**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:** See Below**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA) M. Paul Stovall was present at Zhenhua Port Machinery Company (ZPMC) on Changxing Island, Shanghai, China for the purpose of monitoring the Quality Control process during the fabrication of the Self Anchored Suspension / San Francisco/Oakland Bay Bridge.

New Tower Shop

89-meter Mock-Up: The QA Inspector observed ZPMC welding personnel Dai Lu, ID #048659, performing Flux Cored Arc Welding (FCAW) a stiffener plate on the Strut Sub-Assembly fillet weld number MUB-MA26-30A.

Bay 2

114-meter Mock-Up: ZPMC personnel are installing and tightening bolts on the upper and lower sections of the Mock-Up. This QA Inspector observed ZPMC personnel tightening the bolts with an impact wrench. The Special Provisions require using the turn of the nut method. The QA Inspector spoke to Quality Control (QC) Inspector Lei Tao regarding this and after some time was informed the bolts are temporary in nature and will be removed.

77-meter Mock-Up: This QA Inspector did a Magnetic Particle Testing (MT) verification on welds at the following locations: MUA-MA1-E/F, weld -19, MUSA-SA104-A/B, weld-1 and MUSA-SA104-A/B, welds -6, 7 and 16. The QA inspector observed indications on each of the welds except for weld number MUSA-SA95, weld-1. The indications were marked and QC was informed.

WELDING INSPECTION REPORT

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This QA Inspector observed Plate material for the 15-meter partitions are being cut to size.

Bay 3

This QA Inspector observed ZPMC personnel removing paint from plate at WT stiffener locations prior to fit up and tack welding. The QA Inspector observed ZPMC welding personnel Li Wenguo, ID #066261 and Xu Changxue, ID #066002 fitting and tack welding stiffeners onto Side Plate (SP) 147-001 and SP028-01 using the SMAW process and Welding Procedure Specification (WPS) WPS-B-P-2112-FCM. ZPMC personnel ground the tack welds in preparation of the fillet welding at the gantry welding station.

This QA Inspector observed CWI Chen Chi Ming monitoring welding at the gantry welding station on SP360 and SP306. After welding had been completed ZPMC personnel were observed drilling holes in the flanges, at each end.

This QA Inspector observed ZPMC, CWI Chen Chi Ming perform and accept a visual inspection on SP061-01.

This QA Inspector observed FCAW welding in process at gantry welding station #1 on BP022-01.

Bay 4

This QA Inspector observed ZPMC personnel welding temporary lifting lugs on various Diaphragm Plates. ZPMC QC personnel were present and monitoring the work.

Summary of Conversations:

As noted in the body of the 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
