

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-002467**Date Inspected:** 06-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Zhang Lei, See Below**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:**

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

New Tower Shop

At the 89-meter Mock-Up: The QA Inspector observed ZPMC personnel grinding on various welds on the exterior of the Mock-Up. They were Stiffener to Diaphragm Plate, Lug to Diaphragm, and Lug to Stiffener welds. These welds were made using the Flux Cored Arc Welding (FCAW) process and are fillet welds.

Bay 3

ZPMC personnel ground on the faying surfaces of cut W12 x 57's. ZPMC personnel were observed by the QA inspector to be Heat Straightening welded Side Plate panels both during and after the process, QC checked the flatness of the panels. ZPMC personnel fit and tack welded stiffeners onto the following Side Plates: SP093-01, SP306-001, SP016-01 and SP509-001. He Yumei, ID #048625, Dai Lu, ID #048659 and Zhang Feng, ID #049769 were the welding personnel.

ZPMC QC and American Bridge / Fluor (ABF) QC personnel performed and accepted a visual inspection of the fillet welds on SP028-001.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA Inspector was informed by ZPMC QC that personnel are going to start performing work on two (2) Critical Weld Repairs (CWR) at 1300 hours. This QA inspector observed work did not actually start until 1345 hours. The defective welds on CWR-022, on SP-012-01 and CWR-023 on SP-015 were removed by carbon arc gouging. The welds were then ground and Magnetic Particle Tested (MT) to ensure the complete removal of the defects. They were then repaired by welding.

The QA inspector observed FCAW welding on SP333-001 at the forward gantry by ZPMC welding personnel : Wang Zhonghua, ID #053753, He Yumei, ID #048625, Dai Lu, ID #048659, Zhang Feng, ID #049769, and Lv Peng, ID #048617.

Bay 4

ZPMC personnel were observed Heat Straightening various Diaphragm Plates and checking the flatness through out the process.

ZPMC Welding personnel Han Ziaofeng, ID # 054467 is welding lifting lugs onto various Diaphragm Plates. The QA Inspector verified the welding parameter and recorded 209 amperes. The work appeared to comply with the contract requirements.

Summary of Conversations:

No Substantial Conversations took place.

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
