

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-002481**Date Inspected:** 18-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan hua**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**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	Deck Panel	NA	NA	Fitup/Welding

OBG Bay 1: Caltrans QA observed ZPMC shop workers performing fitup and tack welding, closed u-ribs to deck plate, assembly identified as DP569-001. The tack welder is identified as Mr. Li Hua bei, welder stamp #059472, utilizing welding procedure WPS-B-T-2342-U2 (rib), revision 0. Caltrans QA observed ZPMC QC/CWI inspector, Mr. Li Yan hua monitoring the welding activities at the workstation. The following digital picture illustrates fitup and tack welding closed rib to deck plate.

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- 2 Deck Panel 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 DP619-001 partial joint penetration (PJP) welds 004 through 009, 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 DP619-001 and typical markings, identifying weld indications.



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

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Reviewed By: Cuellar,Robert

QA Reviewer