

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-002511**Date Inspected:** 27-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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/Tower	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue 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.

Tower Bay 1: QA Inspector performed ultrasonic verification testing of skin plate Complete Joint Penetration (CJP) butt joint after ZPMC QC UT acceptance. QA Inspector UT tested plate ESD1 SA216 A/K 13b side "B". QA Ultrasonic Testing (UT) was performed to verify that a minimum of 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 and 45 degree angle wedges from face A. For details please see the ultrasonic testing report TL-6027 dated April 27, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

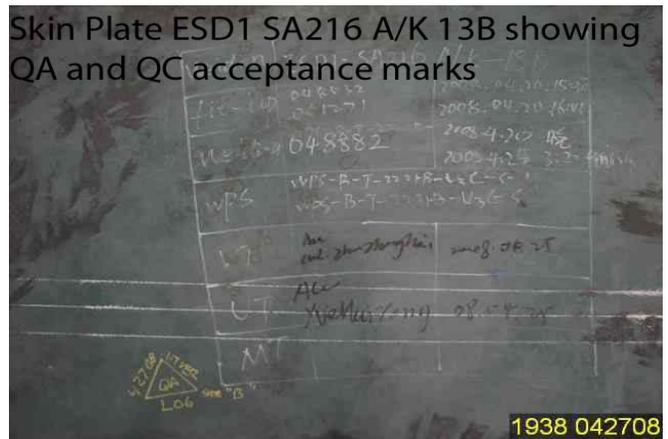
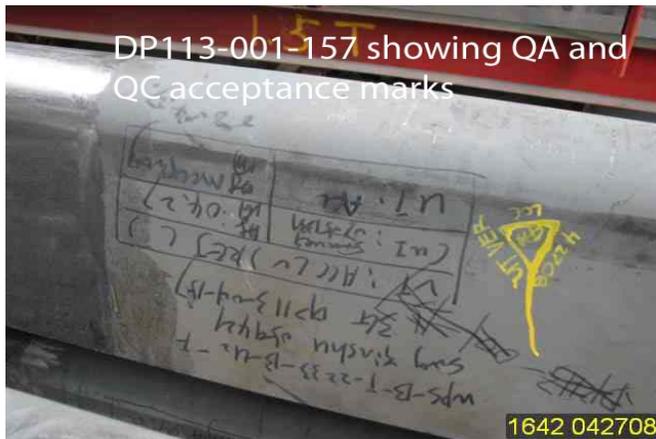
Bay 3: QA Inspector performed ultrasonic (UT) verification testing of Side Panels Complete Joint Penetration (CJP) welds at joints SP121-001-001, SP148-001-001, SP361-001-001, SP334-001-001, and SP307-001-008 after ZPMC QC acceptable UT inspection. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated April 27,

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2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

Bay 1:QA Inspector performed ultrasonic (UT) verification testing of Deck Panel U Rib Complete Joint Penetration (CJP) welds at joint DP113-001-157 after ZPMC QC acceptable UT inspection. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated April 27, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.



Summary of Conversations:

No significant conversations this day.

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: Prue,Erik

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer