

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-002633**Date Inspected:** 06-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Jian Jing Fei**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:** Tower**Summary of Items Observed:**

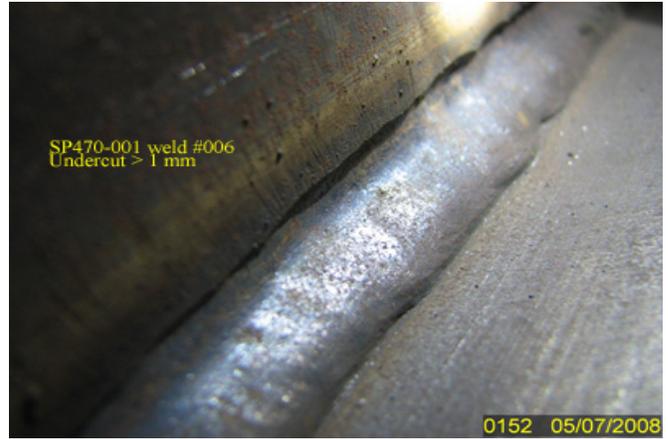
Caltrans Quality Assurance (QA) Inspector, Larry Viars was present observe production welding of the deck plate U-rib splice welds and perform random Visual Testing (VT) of the Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector observed ZPMC welder Mr. Song Yin Shua performing Flux Cored Arc Welding (FCAW) on U-rib Complete Joint Penetration (CJP) splice welds DP383-001-191 and DP383-001-192 in the 3G position. Splice welds were back gouged to sound metal, ground smooth, and welding completed. The following parameters were recorded from weld DP437-001-190, amperage 204, volts 25.0, travel speed of 108 mm/min., with a heat input of 2.83 kJ/mm. The above mentioned welding appeared to be in conformance with the posted welding procedure specification, WPS-B-T-2233-B-U2-F.

The Caltrans QA Inspector went to verify Magnetic Particle Testing that had been accepted by ZPMC Quality Control (QC) on side plate SP470-001 stiffener fillet welds 001 through 014. Upon arrival numerous areas of overlap, undercut, base metal excavations at the fillet weld to stiffener toe that exceeded 1 mm were found. These areas were shown to ZPMC QC Mr. Xu Jun. Mr. Jun stated these areas would be repaired. Please see the attached photos of overlap and undercut on SP470-001 fillet welds below.

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

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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