

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-002666**Date Inspected:** 23-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**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 and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna 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 Skin Plates

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the skin plates splices weld joints #ESD1 SA-233 E/F-25, ESD1 SA77A A/E-35A, ESD1-SA77 A/E-37A, ESD1-SA77A/E 37B, ESD1-SA77 A/E 35B, ESD1-SA233 E/F-25A, ESD1-SA 49 C/D 18A, ESD1-SA 49 C/D 9A, ESD1-SA 49 C/D 12A, ESD1-SA 49 C/D 15A, WSD1-SA107 D/J 16A, WSD1-SA 107 B/J 17A. The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL_6027 generated on this date. The QA inspector had a conversation with Task Leader David McClary. The QA inspector brought to the attention that ZPMC was performing Ultrasonic testing on areas where the joint geometric was other than the specified on the AWS D1.5(2002). ZPMC was beveling one of the side of the 90 mm skin plate before welding. After welding ZPMC UT at the end of the joint over the bevels at the weld joints ESD1 SA77A A/E-35A, ESD1-SA77 A/E-37A.

Mr. David McClary informed the QA inspector and task Leaders Jimmy Cochran and Robert Cuellar that ZPMC could proceed and scan over the bevel using the scanning procedures listed on the AWS D1.5 (2002).

OBG Side Panels

The QA inspector performed UT at the completed joint penetration at the side plates splices weld joints # SEG-020A-022(jointing side plates SP44A/SP56A), SEG-014-008(jointing side plates SP-51A and SP-39A) and SEG-014-025(jointing side plates SP-52B and SP-40B). The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract

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documents. See UT report TL_6027 generated on this date.

Summary of Conversations:

As noted above.

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:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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