

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002755**Date Inspected:** 30-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:** Jiang Jian 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:** OBG and Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present observe production welding of Tower components and record visual discrepancies of Orthotropic Box Girder (OBG) Deck Panels, 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. Gao Guimei performing Submerged Arc Welding (SAW) on Tower Skin plate C weld joint ESD1-SA294 A/G 12B for East Tower in the 1G position. Welding procedure specification WPS-B-T-2221-B-U3C was posted for the above mentioned root pass. The following welding variables were recorded, amperage 632, volts 33.5, travel speed 614, with a heat input of 2.06 kJ/mm. The above mentioned welding appeared to meet the requirements of AWS D1.5 (2002) and applicable contract documents. Please see the attached photo of ZPMC personnel grinding the above mentioned root pass after welding.

The Caltrans QA Inspector recorded the Y location and length of discontinuities marked by swing shift personnel on OBG deck panel DP406-001 welds 001 through 009. The data recorded for DP406-001 was filed and distributed to the appropriate personnel for review.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No relevant conversations occurred this date.

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
----------------------	-------------	-----------------------------

Reviewed By:	Cuellar,Robert	QA Reviewer
---------------------	----------------	-------------