

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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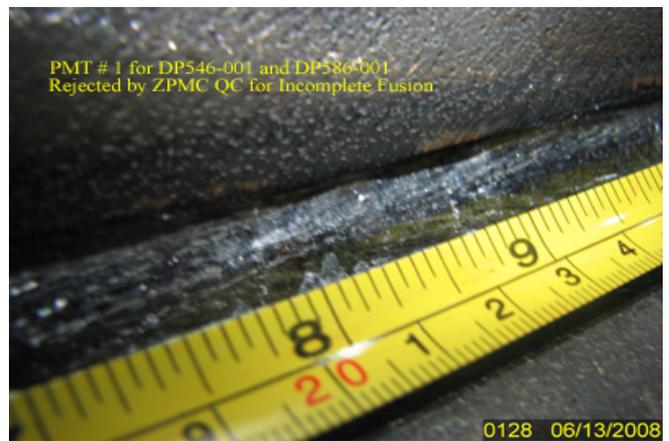
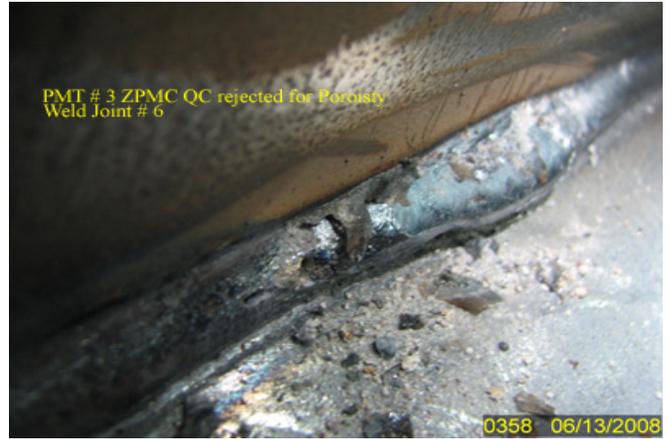
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002966**Date Inspected:** 12-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Chen Xi**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, Larry Viars was present to monitor activities associated with the Production Monitoring Test of Orthotropic Box Girder (OBG) Deck Panel U-rib welds, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP561-001 and DP546-001. The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. Four attempts were made for an acceptable PMT. The first PMT was rejected by ZPMC Quality Control (QC) for Incomplete Fusion on the cover pass of weld # 6. The second PMT was rejected by ZPMC QC for a welding head malfunction on weld # 3 (welding head # 3). The third PMT was rejected by ZPMC Porosity on weld # 6. The fourth and final PMT for the shift was rejected by ZPMC QC for excessive penetration on the root pass. ZPMC QC stated that work would resume on the day shift after additional PMT panels were fabricated. Please see the attached photos below of PMT welding discontinuities rejected by ZPMC QC.

WELDING INSPECTION REPORT

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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
Reviewed By:	Cuellar,Robert	QA Reviewer
