

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-003001**Date Inspected:** 06-Jun-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:** 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.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the floor beams connections weld joints # FB-003-13-103, FB-003-07-103, FB-003-07-006, FB-003-07-032, FB-003-07-033, FB-003-07-020, FB-003-07-008, FB-003-07-001, FB-003-11-103, FB-003-11-044, FB-003-11-032, FB-003-11-020, FB-003-11-008 and SP-13A-PP023-137 and SSD15-PP019-133. 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 performed random visual weld inspection to the floorbeam FL-2-1 connections. The QA inspector found weld undersized (required fillet weld reinforcement 8 mm as per approved weld detail drawings) at the junction of the connection plate to the bottom flange from the floor beam FL-2-1 at the following locations: SSD19A-PP024-133(5 mm fillet weld reinforcement), SSD19-PP024-136(4 mm fillet weld reinforcement), SSD16-PP020-005(3 mm fillet weld reinforcement), SSD16A-PP020-132(4-5 mm fillet weld reinforcement), SSD19A-PP023-137(3mm fillet weld reinforcement)and SSD19A-PP023-133(3 mm fillet weld reinforcement). The QA inspector had a conversation with ABF representative Peter Shaw. The QA inspector brought to his attention that: 1. Several welds were undersized at the junction of connection plates to bottom flange on the floor beam FL-2-1, 2. ZPMC had weld defects overlooked by ZPMC QC to be repairs at the floor beam connection and 3. ZPMC had not performed magnetic particle inspection at the ends of those connection after the removal of the

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run-off tacks. Mr. Peter Shaw agreed. The QA inspector informed Mr. Peter Shaw that the QA inspector was going to recommend an incident report to be written on this matter.



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
Reviewed By:	Cuellar,Robert	QA Reviewer
