

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-003157**Date Inspected:** 23-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1930**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:** Wang Sai Fa**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 DP572-001 and DP577-001. 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. Three attempts were made for an acceptable PMT. The first PMT was rejected by ZPMC Quality Control (QC) for Overlap and Undercut on the cover pass of weld # 3 and 6. The second PMT was rejected by ZPMC QC for Undercut and Overlap on welds # 1 and # 6. The third and final PMT was rejected by ZPMC QC for linear indications in the tack welds. ZPMC attempted to repair these areas after noting that areas of MT excavation corresponded with deep undercut. The repairs were not successful and indications were still present. ZPMC QC Mr. Wang Sai Fa rejected the panel for indications in the tack welds. The PMT was put on hold until ZPMC could fabricate PMT panels. Please see the attached photos of undercut associated with MT excavation areas.

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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
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Reviewed By:	Cochran,Jim	QA Reviewer
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