

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-003183**Date Inspected:** 26-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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**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 observed ZPMC performing layout, cutting, beveling, milling, fitting and welding activities in bay # 1 and 2 on the Tower Assembly shop.

The QA inspector observed ZPMC welding operators Xun Chuan Jin 0503060 and Lui Zhen Hong performing welding operations with the submerged arc welding (SAW) process using the WPS-BT2221-U3 c-S in the flat (1G) position at the weld joint # SSD1-SA178 C/D-24B and SSD1-SA173 A/K-14A respectively skin plate connections (butt joint). The QA inspector performed random welding parameters verifications. The QA inspector found that the welding parameters appeared to be in compliance with the contract documents.

The QA Ultrasonic testing (UT)

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the skin Plate connection for the skin A, South Lift # 1, joints # NSD1-SA-159-D/J 1-B, NSD1-SA-33A/J-25B, NSD1-33A/F 24B, diaphragm ring connection SSD1-SA-326-6A and 7A and diaphragm connection WSD1-SA-316-A/B-12A, NSD1-SA-248-1A and SSD1-SA-169-A/B-1A. The QA inspector was performing 10 % UT at random location. The QA inspector found that welds appeared to be in compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any conversation on this date.

WELDING INSPECTION REPORT

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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:	Cochran,Jim	QA Reviewer
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