

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-003437**Date Inspected:** 31-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**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 observe and monitor fabrication and perform Non Destructive Testing of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Sub Assembly Bay # 1 (OBG)

Caltrans QA Inspector observed ZPMC in the process of fitting and tack welding OBG Deck Panel DP563-001 closed rib PJP weld joints utilizing the Gas metal Arc Welding (GMAW) process in the 2G position per WPS-B-T-2342-U2 (U2b). The fit-up and GMAW welding were found to be in compliance with project specifications. QA observed ZPMC continuing with the fabrication of various deck plate components designated for the SAS OBG. The general fabrication of said items consisted of removing of coating from weld joint areas, milling and the drilling of bolt holes.

Sub Assembly Bay # 3 (OBG)

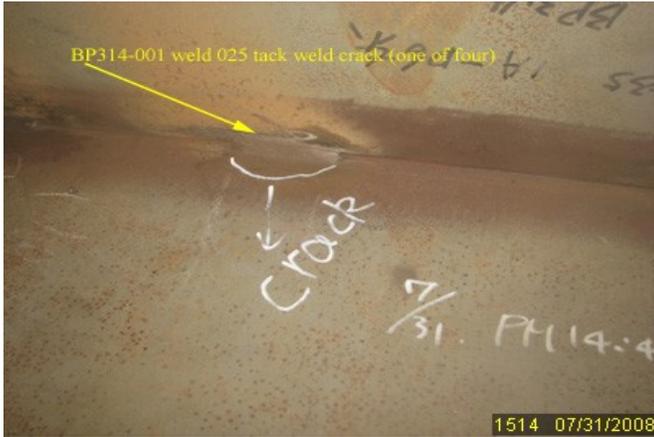
QA was informed by ZPMC Quality Control Huang Wen Pang that 4 tack welds on Bottom Plate BP314-001 weld 025 were cracked. QA observed Tack weld cracks ranging from 15 to 80 mm in length. Areas of cracking were excavated and Magnetic Particle Testing performed. QA witnessed ZPMC QC test and accept weld excavations. Please see the attached photo below of tack weld cracks prior to excavation.

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Sub Assembly Bay # 4 (OBG)

QA performed 10% verification Magnetic particle Testing (MT) on the following fillet welds joining stiffeners to side and bottom panels, SP654-001, SP190-001, SP199-001 and BP305-001. All of the welds that were examined appeared to comply with AWS D1.5 2002 and the contract documents. Please see MT report-6028, generated on this date for further information.



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 Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

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| Inspected By: | Viars,Larry | Quality Assurance Inspector |
| Reviewed By: | Lanz,Joe | QA Reviewer |
