

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-003565**Date Inspected:** 22-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 Assembly**Summary of Items Observed:**

Orthotropic Box Girder (OBG) Fabrication

Caltrans Quality Assurance (QA) Inspector Robert Vatcher, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following: The weather today is 27C and clear.

QA performed ultrasonic testing (UT) in tower shop bay 8 on the following 60 mm to Tower Edge Plates piece marks to support the required non destructive testing per the contract documents.

WSD1-SA32A/B-4A

WSD1-SA32A/B-5A

WSD1-SA32A/B-6A

WSD1-SA32A/B-7A

WSD1-SA32A/B-8A

WSD1-SA32A/B-9A

Which supports 10% UT requirement for WSD1-SA32A/B-3A & WSD1-SA32A/B-11A as well.

Heavy Shop 1

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QA performed Magnetic Particle Testing (MT) in Heavy Shop 1 on the following Tower Skin Plate piece marks

SSD1-SA173A/K-20A (B)

SSD1-SA173J/K-7A (B)

SSD1-SA173A/K-13A (B)

SSD1-SA16 F/G-88A (B)

SSD1-SA16 F/G-112A (B)

to support the required non destructive testing per the contract documents. Weld SSD1-SA173J/K-7A (B) revealed 2 linear indications 62 mm and 75 mm in length which appeared to be indications from remaining weld contour. QA inquired to AB/F QC in Heavy Shop 1 about the situation. QC then instructed the welding assistant present in the shop to grind smoothly the affected areas. Post grinding of the affected locations by the MT method revealed no linear indications remaining.

OBG Assembly Shop

QA performed ultrasonic testing (UT) in OBG Assembly Shop on the following 20 mm to 12 mm transitioning weld Side Plate to Deck Plate (E7 + D6) piece marks to support the required non destructive testing per the contract documents.

SEG019A-019

SEG19A-025

The above mentioned items as observed and examined by QA appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations 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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Vatcher,Robert

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer