

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-003585**Date Inspected:** 20-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**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 and Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Magnetic Particle Testing (MT) of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Tower Heavy Machinery Shop Bay # 1

The Caltrans QA Inspector performed Magnetic particle Testing (MT) verification of the following ZPMC QC inspected and accepted Tower Skin Plate C Longitudinal stiffener Complete Joint Penetration (CJP) welds, SSD1-SA17A/G 19B, 21A, 22A, SSD1-SA179 C/E 14A, 12A, 9A, 8A, SSD1-179 D/E 2B, 3B, 4B, SSD1-B2/E 1B and SSD1-SA179 B/E 2B. ZPMC had one area on the end of weld SSD1-SA179 B/E 1B where the excavation after MT exceeded 3 mm that required repair. ZPMC QC Mr. Jiang Jian Fei stated the area would be repaired prior to installation. All of the welds that were examined appeared to comply with AWS D1.5 2002 and the contract documents. See MT report TL-6028 generated on this date for further information.

Sub Assembly Bay Shop # 1

This QA Inspector observed ZPMC personnel performing various activities in relation to OBG deck panel Production Monitoring Test and production fabrication. Activities included ZPMC performing MT the PMT tack welds after grinding, grinding U-rib Complete Joint Penetration (CJP) Splice welds and tack welding of U-ribs to deck plate. Please see the attached Photo below of ZPMC QC performing MT on PMT tack welds. Testing and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

fabrication activities appeared to in general conformance with contract documents.

Sub Assembly Bay Shop # 4

This QA observed ZPMC welder ID #037780, ID #068253 and ID #068250 SMAW(3G) tack welding on tower double diaphragm web plate to web plate Partial Joint Penetration welds, NSD1-SA322 A/B 13, 14, and 15. The QA Inspector randomly observed ZPMC CWI Zhao Chen Sun monitoring weld parameters. The welding parameters observed appeared to be in general conformance with the approved posted Welding Procedure Specification WPS-B-T-3313-TC-P5.



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.

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