

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-003639**Date Inspected:** 12-Aug-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:	NA	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 Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, 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:

Orthotropic Box Girder (OBG):

Heavy Tower Shop #3:

Around 1500 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC QC and ABF QA Inspection personnel have completed final visual inspections of the closed rib welds on deck panels DP109-002, DP433-001, DP190-001 and DP352-001 and the deck panels are ready for QA final visual inspections.

The QA Inspector performed random visual inspections of each of the welds on deck panels DP109-002, DP433-001, DP190-001 and DP352-001 and items observed appear to comply with project specifications. The QA Inspector documented these visual inspections on the yellow inspection tags attached to each of the deck plates adjacent to where ZPMC and ABF Inspectors had documented their inspections.

Around 1500 hours Mr. Fu Yuhong informed the QA Inspector that ZPMC NDE personnel will be performing final magnetic particle inspections of the welds on deck plate DP406-001 and these welds will be ready for QA to perform magnetic particle inspections of these welds. The QA Inspector performed random magnetic particle inspections of the ten welds on DP406-001 and items observed appear to comply with project specifications.

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Around 1900 hours Mr. Shen Xue Jun submitted a “Notification of Witness Inspection” document #839 stating that deck panel closed rib welds on DP352-001, DP109-002, DP433-001 and DP190-001 are to be magnetic particle inspected at 1930 hours. Around 1945 hours the QA Inspector observed ZPMC MT inspector Mr. Wang Wei performing magnetic particle inspection of DP109-002 and he marked a transverse indication in the face of weld #2 approximately 50 mm from the end of the weld opposite of where the yellow SFOBB QA Verification In Process” tag is located. Mr. Wei then performed magnetic particle inspections of an additional 3 meter length adjacent to the transverse indication in weld #2. The QA Inspector performed random magnetic particle inspections of all four of the deck panels and items observed appear to comply with project specifications. See the TL6028 Magnetic Particle Test Report dated 8-12-2008 for additional information.

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The QA Inspector observed ZPMC Ultrasonic Inspector Mr. Xu Rong Gang performing ultrasonic inspections of tower weld SSDI-SA248 weld 5A. The QA Inspector observed Mr. Gang verifying the angle of his transducer to be approximately 70° which is in compliance with AWS D1.5 angle limitations and Mr. Gang used a setting of 35.8 DB (decibels) to establish an 80 % screen height reference level on his ultrasonic machine. Mr. Gang first scanned the base material with a 0° transducer then he scanned the flush ground weld with his 70 degree transducer. Items observed appear to comply with project specifications.



Summary of Conversations:

See above.

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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer