

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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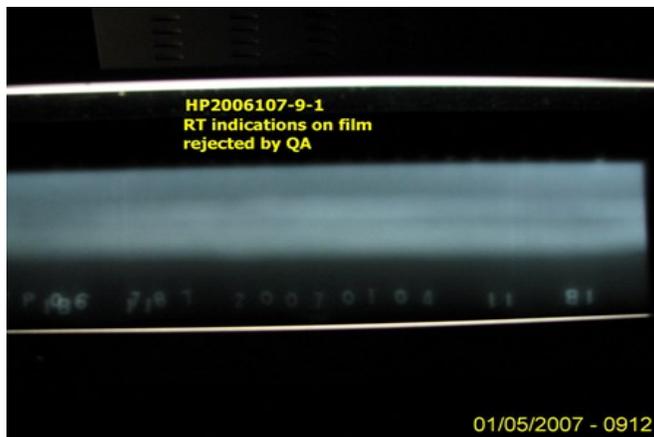
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000050**Date Inspected:** 05-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Liu	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:		

Summary of Items Observed:

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright observed quality control functions related to procedure qualification (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA Inspector reviewed the Radiographic Testing (RT) film for 1G (horizontal) Flux Core Arc Welding (FCAW) Procedure Qualification (PQR) identified as HP-2006107-9-1. The QA Inspector observed indications on the film in the area of interest which did not comply with figure 6.8 of AWS D1.5-2002. The Quality Control for ZPMC stated that the weld cap would be ground down and the PQR plate re-shot by radiographic testing.



WELDING INSPECTION REPORT

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Summary of Conversations:

The Quality Control (QC) representative for ZPMC stated that the indications on the film was from the weld cap and that he believed that the weld was good. The QA stated that the weld cap would have to be removed as per contract documents prior to radiographic testing so that the weld cap would not mask any defects in the weld zone.

The QC stated that the code allowed the weld reinforcement to remain. The QA reconfirmed that the welds to be radiographed shall be ground smooth and flush as per the Standard Specifications.

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:	Wright, Mark	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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