

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-000221**Date Inspected:** 12-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	Mock Up Material Verification	

Summary of Items Observed:

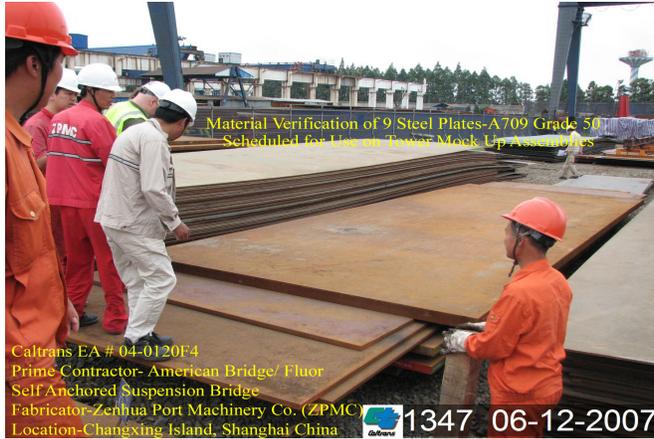
Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the fabrication facility of Zhenhua Port Machinery Company (ZPMC), LTD for the purpose of monitoring activities relative to the subsequent fabrication of the SFOBB Self Anchored Suspension Bridge. The following items have been observed,

Item	Description	WBS	Dwg No.	Status
1	Mock-Up Material Verification	N/A	N/A	N/A

The Caltrans QA Inspector's presence was requested by ABF representative Mr. Jeff Evans for the purpose of observing nine (9) steel plates scheduled for use on the tower mock up assemblies. The Caltrans QA Inspector was escorted along with Mr. Jeff Evans by Mr. Fu Yuhong of ZPMC. The Caltrans QA Inspector observed that the presented steel plates are identified as A709 Grade 50 material and are of thicknesses of 25mm, 35mm, 60mm, 70mm and 90mm with a variety of size dimensions. The appearance of these plates contained rust and are in a stacked position as identified in the picture below.

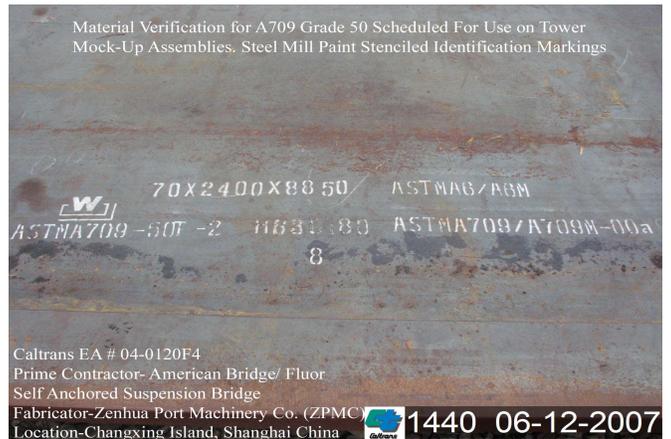
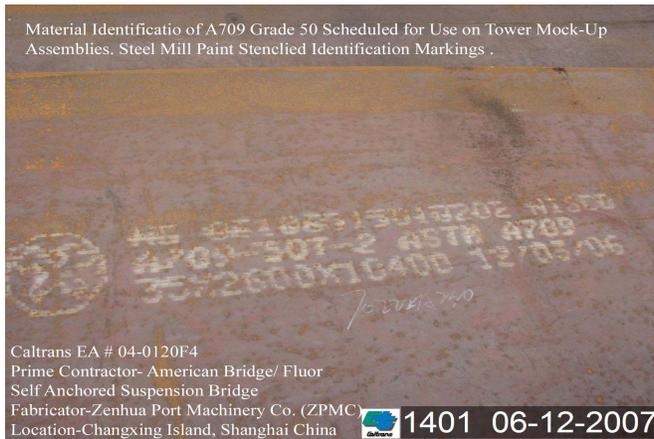
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2 Mock-Up Material Verification N/A N/A N/A

ZPMC unstacked each plate to provide visible access to the surface that contained the producing steel mills painted identification markings stencil. The Caltrans QA Inspector observed that the painted identification markings were not all easily legible as identified in the digital picture below. The Caltrans QA Inspector did identify that some of the steel plates did contain identification markings that were clearly legible as identified within the digital picture below. Some of the steel plates presented contained steel died stencils that were identifiable as well as some that could not be identified.

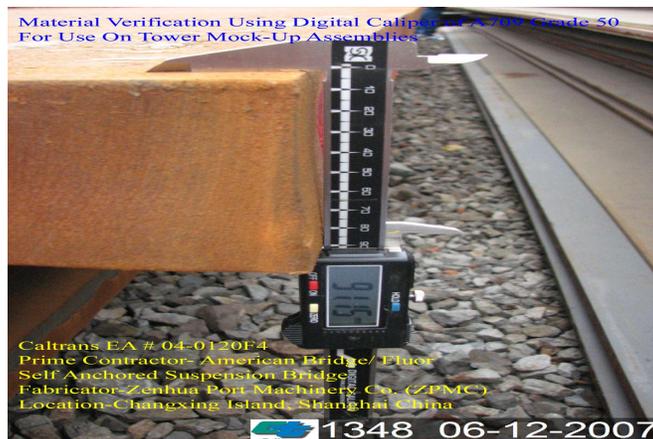
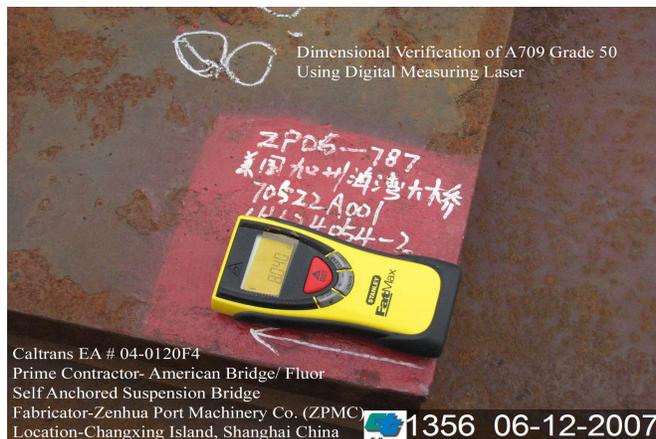


3 Mock Up Material Verification N/A N/A N/A

The Caltrans QA Inspector performed dimensional measurements utilizing a digital caliper for measuring plate thicknesses and also a laser for measuring the width and lengths of randomly selected plates as identified within the digital pictures below. The ABF representative did not perform any dimensional verification of the presented steel plates while the Caltrans QA Inspector was present.

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4 Mock-Up Material Verification N/A N/A N/A

The Caltrans QA Inspector recorded the heat numbers that were paint stenciled on each plate for comparison with the supporting Material Test Reports that were provided by ZPMC. The Caltrans QA Inspector identified and brought it to the attention of ABF, Mr. Jeff Evans that several of the supporting Material Test Reports are unlegible. Mr. Jeff Evans stated that ABF would present legible Material Test Reports at a later date. Verification of the physical and chemical properties for the recorded heat numbers with supporting Material Test Reports was not performed on this date for the presented A709 Grade 50 steel plate.

Summary of Conversations:

As identified within the last paragraph listed within the Summary of Items Observed.

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: Cuellar, Robert Quality Assurance Inspector

Reviewed By: McClary, David QA Reviewer