

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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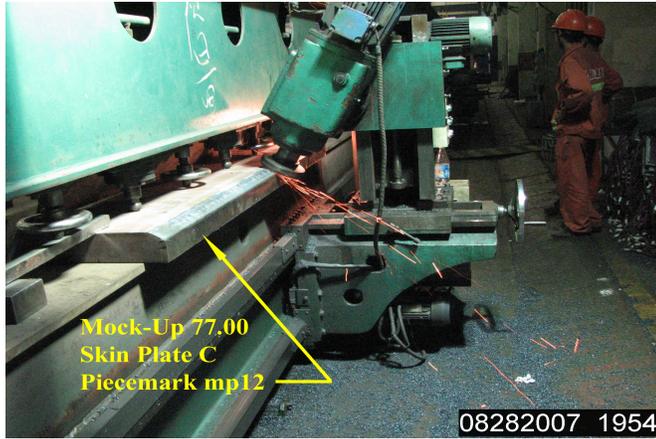
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000395**Date Inspected:** 28-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime 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:** Ye Yong Jun**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:** Caltrans Mock-Up 77.00**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup and welding of the Caltrans Mock-up #77.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing the beveling on subassembly, Skin Plate C, perimeter plate edge. The beveling is being performed on the ZPMC milling machine. The skin plate subassembly is made-up of three plates (mp13, MA4, mp12) that have been welded together. The assembly is positioned with the inside side up on the mill machine table, then aligned and held in place clamps. ZPMC is observed in the process of milling the single 30 degree bevel for plate, piecemark mp12. The 30 degree bevel for piecemark mp 12 double bevels has been completed. It appeared that the 45 degree bevel for this plate has been flame cut. ZPMC QA inspector Mr. Lay Tao stated that this cut was a preliminary cut and that this flame cut bevel would be completed by milling the bevel to the finish bevel angle cut. Caltrans QA randomly verified the milling in process and completed bevel. The bevel surface finish, bevel angle and bevel off-set were in conformance with contract specifications. Following digital pictures illustrate machining in progress and completed bevel.

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Item	Description	WBS	Dwg No.	Status
1	Skin Plate B & E	NA	NA	Fabrication in process

Caltrans QA Inspector questioned ZPMC QA inspector, Mr. Lay Tao in regards to the status and whereabouts of Skin Plate B, E and D. ZPMC QA stated that ZPMC has completed the heat straightening of skin plate B and is located at the burn table. ZPMC has completed the flame cutting of the two holes on Skin Plate E and is located at the burn table. Caltrans observed that no further work has been performed on either the assemblies and that it appears that ZPMC is in the process preparing Skin Plate D, for welding of the longitudinal stiffeners and is located at the front of the shop. Following digital pictures illustrates Skin Plate B and Skin Plate C.



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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

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Reviewed By: Cuellar,Robert

QA Reviewer