

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-000441**Date Inspected:** 09-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lu Guoxuan	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:	N/A	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77, 89 and 114 meters elevations scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Mock-up 89 Meters Elevation

The QA inspector observed ZPMC welders Han Xiofeng and Wang Zhoghua performing tack welding operations at the top diaphragm splice at the junction of plate P1236 to the SA13. The QA inspector performed random verifications of the welding parameters. The QA inspector observed that the welding parameters appeared to be in compliance with the contract documents. The QA inspector observed CAWI Fu Guogang performing fit-up and welding verifications within audible and visual range from the approved CWI Lu Guoxuan.

Tower Mock-up 77 Meters Elevation

The QA inspector witnessed ZPMC Magnetic particle testing (MT) on the cover pass for the partial penetration joints at the junction of the skin panel D to stiffeners plates, weld joints # 3, 4, 5, 6, 7, 8, 9 and 10. The QA inspector observed MT ASNT Level II technician Zhou Dongyun performing MT verifications. The QA inspector observed that Mr. Zhou MT verifications appeared to be in compliance with the Contract documents. The QA inspector performed 100 % visual examination (VT) verification for the cover pass from the skin upper panel D weld joint # 3 thru 10 respectively. The QA inspector observed that the weld examined appeared to be in accordance with the contract documents.

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The QA inspector performed 10 % MT verification on the cover pass from the skin upper panel D weld joint # 3 thru 10 respectively. The QA inspector observed that the weld examined was in accordance with the contract documents. See TL 6028 generated on this date.

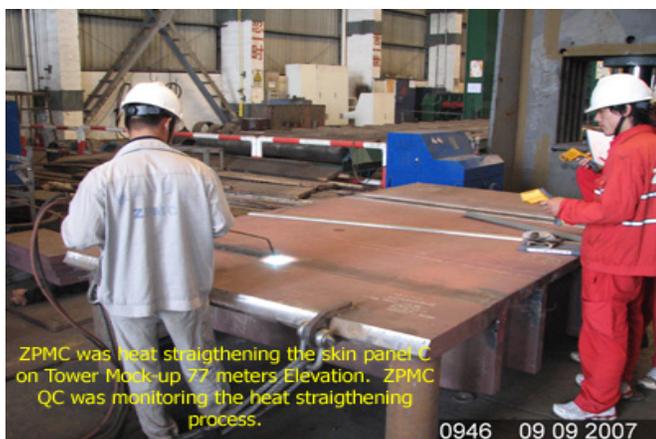
Tower Splice Mock-up 114 Meters Elevation

The QA inspector performed 100 % visual examination (VT) verifications on the backgouged area at the junction of the skin lower panel B to the connection plate mp1009 weld joint # 3. The QA inspector observed that the backgouged area (before welding) appeared to be in accordance with the contract documents.

ZPMC, welder Li Guoxuan was observed by the QA Inspector performing tack welding operations at the junction of on the skin B upper panel MA101 to stiffener mp1009.

Mr. Li was following the approved welding procedure specification WPS-B-P-2211-TC-U4b. Base metal was designated as A-709 Grade 345. ZPMC was using the Shielded Metal arc welding (SMAW) process in the horizontal (2G) position with the 4.0 mm diameter electrode designated as E7018/AWS A5.1, brand name TL-508.

The QA Inspector verified amperages, preheat and heat interpass temperatures. The QA inspector found that the welding parameters reported by approved ZPMC Certified Welder Inspector Lu Guoxuan appeared to be in accordance with the contract documents.



Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

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: Acuna, Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer