

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000467**Date Inspected:** 16-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**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:** 114 Skin C & 89**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Ultrasonic Testing (UT) of the Caltrans Mock-up #89.00 and Magnetic Particle testing (MT) and Visual Testing (VT) of Mock-up #114.00, 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 QC performing UT on Mock-up 89.00 P1236 to SA13 Complete Joint Penetration (CJP), and MT of Mock-up #114.00 Skin Plate C sub assembly MA111 longitudinal stiffener welds. ZPMC QA inspector Mr. Li Xiu Yong stated, the weld number for Mock-up 89.00 was MUB MA21. Caltrans QA observed ZPMC QC perform VT of Mock-up #114.00 Skin C CJP welds #8 & #11.

Caltrans QA Inspector observed ZPMC QC nondestructive technicians, Mr. Li Li Ming and Ms. E Shuiqin performed Ultrasonic Testing on Mock-up 89.00. Mr. Li Liming performed straight beam and 45 degree shear wave testing of the weld joint. Ms. E Shui Qin performed the 70 degree Shear wave testing. The following picture below illustrates Mr. Liming performing Ultrasonic testing of the above mentioned weld. At the conclusion of testing both QC technicians found the weld to be acceptable to AWS D1.5 2002 requirements. Magnetic Particle Testing was performed by Mr. Zhou Dongyun on Mock-up #114.00 Skin Plate C sub assembly MA111 Partial Joint Penetration (PJP) longitudinal stiffener welds 6,7,9,10,12 and 13 root pass. These welds were found acceptable by Mr. Zhou Dongyun. ZPMC QC Je Yongjun performed VT of Mock-up #114.00 Skin C sub assembly MA111 CJP welds #8 and #11. The back gouged CJP welds were found acceptable by Mr. Yongjun.

The Caltrans QA Inspector performed VT and MT examinations of the stiffener weld root pass of #114.00 Skin C and monitored UT testing of Mock-up #89.00. Caltrans QA Inspector observed that the testing appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
