

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-000468**Date Inspected:** 17-Sep-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:** Changxing Island**CWI Name:** Huang Ci**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 B & C**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Ultrasonic Testing (UT) of the Caltrans 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 114.00 stiffener Complete Joint Penetration (CJP) portion of welds on skin B Plate lower and upper sections of skin b and c. Mr. Shen Xui Jun stated, Ultrasonic testing was being performed in accordance with AWS D1.5 requirements.

Caltrans QA Inspector observed ZPMC QC technicians, Mr. Li Li Ming and Ms. E Shui Qin performed Ultrasonic Testing on Mock-up #114.00. Mr. Li Liming performed straight beam and 45 degree shear wave testing of Skin B and C upper section longitudinal stiffener weld joints. Ultrasonic Testing was also performed on Skin B lower section longitudinal stiffener welds. ZPMC QC Ms. E Shuiqin performed the 70 degree Shear wave testing.

Ultrasonic Testing skin plate b upper section sub assembly MA101 ZPMC QC reported one rejectable indication at each stiffeners 1006-2 (Class B) and 1009-2 (Class C). UT of Skin C upper section sub assembly MA112, ZPMC reported rejectable indications at stiffeners 1003-2 (Class A) & 1003-1 (Class A). The above mentioned rejectable indications were marked on the weld and with UT indication rating marked on the adjacent base metal of the stiffener. Skin B lower section sub assembly MA102 ZPMC QC reported that the stiffener welds were found acceptable.

The Caltrans QA Inspector observed Ultrasonic examinations of the longitudinal stiffener welds. QA Inspector observed that the testing appeared to be in general conformance with AWS D1.5 2002 requirements.

Summary of Conversations:

As identified within the contents of this report.

WELDING INSPECTION REPORT

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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
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Reviewed By:	Cuellar,Robert	QA Reviewer
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