

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-000469**Date Inspected:** 10-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Nan**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 Assemblies-77M, 89M and 114M**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-ups 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 for 89 Meters Elevation

QA inspector performed visual inspection of the backgouged area at the junction of P1235 to the p213 after ZPMC ground the groove to bright metal. Due to the observed backgouged area profile relative to the requirements of the joint detail in figure 2.4 of AWS D1.5, the QA inspector requested to ABF representative Kevin Dye and ZPMC representative Li Xiu Yang as to how Quality Control performs verification of the groove profile as per contract documents. ZPMC representatives relayed that there were no dimensional requirements specified in AWS D1.5 2002. The QA inspector showed the applicable sections of the code. ZPMC and ABF representatives agreed that backgouged area needed to comply with figure 2.4. ABF relayed to the QA inspector that even though that ZPMC appeared to comply with dimensional requirements, ABF was going to recommend to ZPMC to make a template for them to use to verify the minimum radius and included angles of the gouged area. At the end of the shift, ZPMC was still grinding the backgouged groove area.

Tower Mock-up for 77 Meters Elevation

The QA inspector observed ZPMC performing heat straightening operations on the skin plate B and D. The QA Inspector had a conversation with ABF representative Kevin Carpenter. The QA inspector relayed to Mr. Carpenter that ZPMC and Catrans performed Magnetic particle testing (MT) at junction of the skin D and

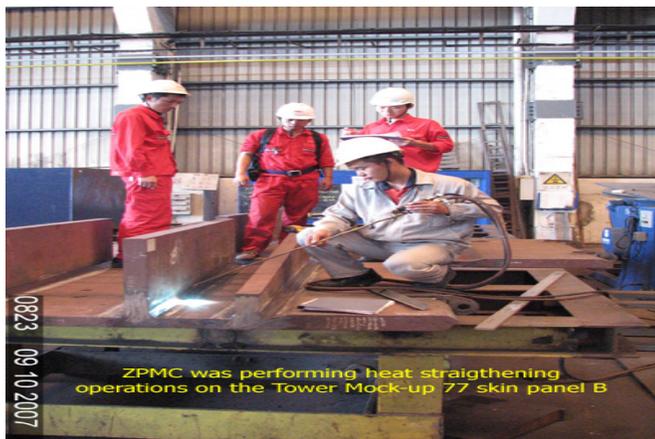
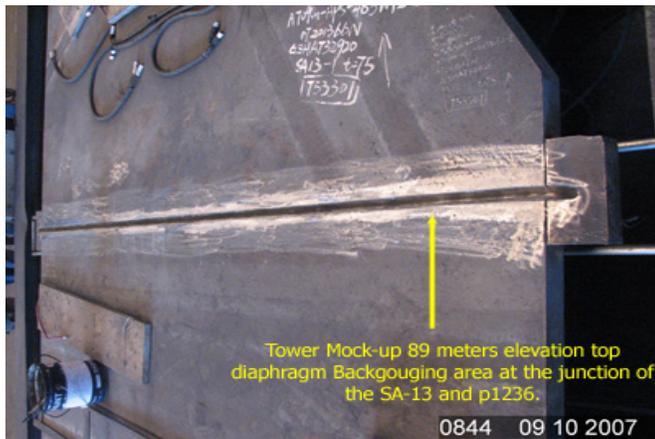
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stiffeners; and ZPMC was heat straightening again. The QA inspector relayed that according to the ZPMC heat straightening control plan and the special provisions, ZPMC needed to perform MT verifications again after heat straightening is completed. Mr. Carpenter agreed and relayed to the QA inspector that ZPMC was going to bring this to the attention of ZPMC representatives.

Tower Splice Mock-up for 114 Meters Elevation

The QA inspector performed 100 % visual examination (VT) verifications for the backgouged area at the junction of the skin upper panel B to the connection plate mp1006 from the skin upper panel D weld joint # 8. The QA inspector observed that the backgouged area (before welding) appeared to be in accordance with the contract documents.



Summary of Conversations:

As noted above.

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.

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Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
