

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-000477**Date Inspected:** 11-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Le Feng & Xu Liang Zhang	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	

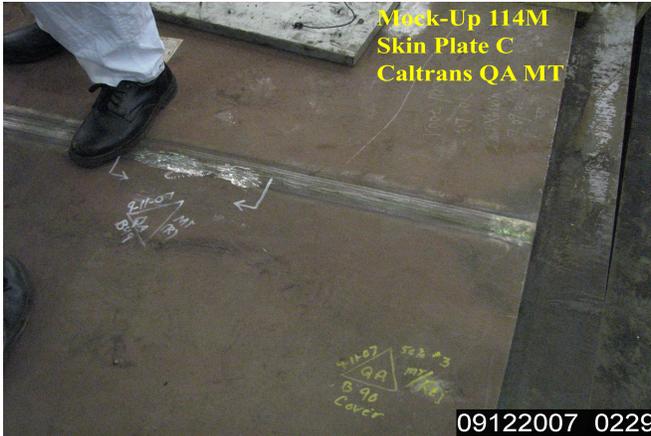
Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M and 114M, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island

Item	Description	WBS	Dwg No.	Status
1	Mock-Up 114M	NA	NA	Work In Progress
	Mock-Up 114M, Skin Plate C (lower section): Caltrans QA Inspector witnessed ZPMC QC perform Magnetic Particle Test (MT) and Visual Test (VT) on weld cover pass MUSC-MA111-3, plate piecemark mp1018-1 to MA111-1, This weld had been previously MT'd and found to be non-compliant by Caltrans QA Inspector, Mr. David Smith. Mr. Smith identified two locations at the cover pass weld for rework. The locations were identified as 502mm to 504mm and 603mm to 700.5mm. ZPMC, QC, NDT technician is identified as, Mr. Cai Xin Xin. The test appeared to be in general conformance with AWS D1.5 2002 requirements. Caltrans QA Inspector performed MT at the locations, as mentioned above. See Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information. The following digital pictures illustrate ZPMC MT in progress and Caltrans QA Inspector's inspection symbol, identifying the inspection of the weld.			

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2 Mock-Up 114M, Skin Plate D NA NA ZPMC MT

Mock-Up 114M, Skin Plate D (CWR001) lower section: ZPMC QA inspector, Mr. Fu Yu hong reported that ZPMC would be performing MT in regards to the CWR001. Mr. Fu Yu hong stated that skin plates had been previously fitup and tack welded together. ZPMC observed crack tack welds. All welds were then removed and the bevels were reconditioned. Caltrans QA Inspector witnessed ZPMC QC perform, Magnetic Particle Test (MT) and Visual Test (VT) of the reconditioned bevels. ZPMC, QC, NDT technician is identified as, Mr. Cai Xin Xin. The test appeared to be in general conformance with AWS D1.5 2002 requirements. At the completion of the testing, ZPMC reported that no relevant indications observed. Following digital picture illustrates MT in progress.



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