

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-000518**Date Inspected:** 12-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:** Lu Jian Ping**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:** Tower Mock-Up for 77M and 114M**Summary of Items Observed:**

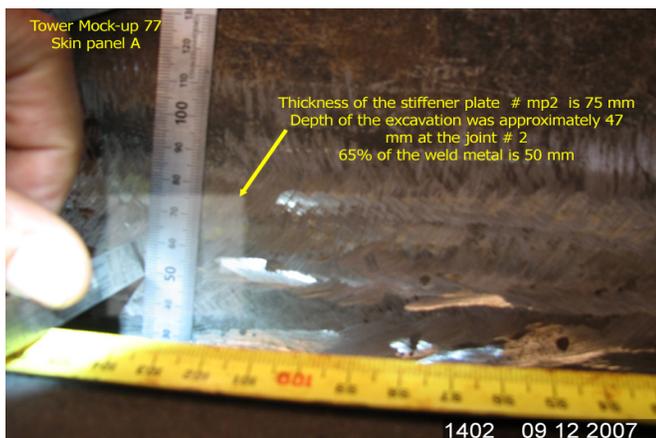
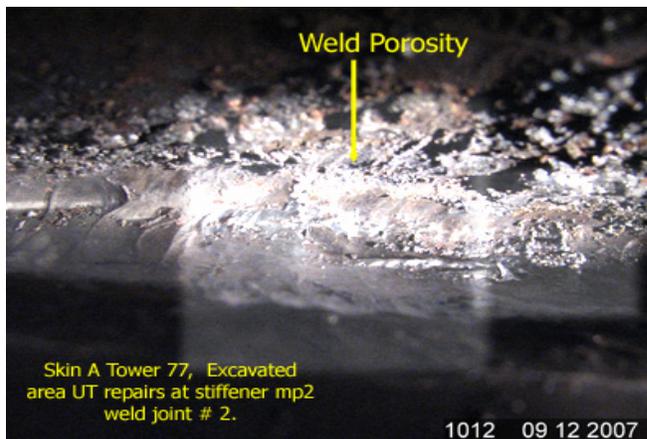
CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 and the 114 meter elevations scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Mock-up 77 Meter Elevation.

The QA inspector observed ZPMC performing air carbon arc gouging operations on the ultrasonically tested (UT) repair areas located at the junction of the skin A and E to the longitudinal stiffeners. The photos below show some of the locations; depth and length after backgouging operations.

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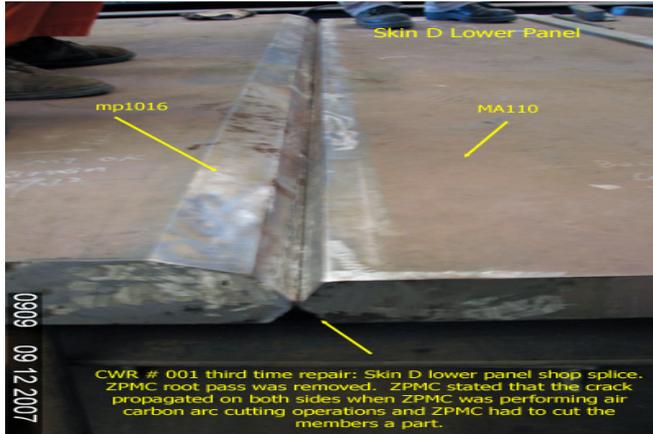


Item	Description	WBS	Dwg No.	Status
1	<p>Critical Weld repair (CWR) # 001 Tower Splice Mock-up 114 Meter Elevation.</p> <p>The QA inspector had a conversation with ZPMC QC Inspector Xu Bing. The QA inspector asked Mr. Xu why ZPMC removed the root pass completely in lieu of 200 mm as shown on the CWR-001. Mr. Xu relayed to the QA inspector that ZPMC asked ABF and ABF agreed with ZPMC to remove the weld completely. The QA inspector had a conversation with ABF representative Craig Knops. Mr. Knops relayed that it could be a misunderstanding, ABF did not agree to remove the root pass completely. The QA inspector had a conversation with QA representative Lu Jian Hua. Mr. Lu relayed to Mr. Knops, Caltrans Structure Representative Mr. Ryan Smith, ABF Representatives Mr.</p>			

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Peter Ferguson and Mr. Steve Lawton that ZPMC removed the root pass (2000 mm of length) because ZPMC chased the 200 mm crack and it propagated through the end of the joint. Mr. Lu added that according to the procedure listed on the CWR-001, ZPMC was allowed to remove the crack completely. The QA inspector relayed to Mr. Lu that the CWR # 001 did not reflect what ZPMC was planning to do after cutting the two plates apart. ABF, ZPMC and Caltrans agreed that the CWR# 001 needed to be revised and resubmitted to reflect what was actually performed.



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.

Inspected By: Acuna, Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer