

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-000565**Date Inspected:** 27-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:** Changxing Island**CWI Name:** Gu Xin Zhai**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 and D**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Magnetic Testing (MT) and Visual Testing (VT) of #114 Mock-up, 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 Quality Control (QC) performing MT on Mock-up #114 Skin D sub assembly MA110 and # 114.00 Skin C sub assembly MA101 longitudinal stiffener welds.

Caltrans QA Inspector observed ZPMC QC technician, Mr. Zhou Dongyun performed MT on Mock-up 114.00 Skin D sub assembly MA110 Partial Joint Penetration (PJP) tack welds # 4, 5, 7, 8, 10, 11, 13, and 14. Caltrans QA observed a QC oversight, a linear slag inclusion 6mm in length and approximately 1mm in width was observed on the CJP side of the longitudinal stiffener tack weld at weld joint # 12 while performing MT of tack welds of weld joint #14. ZPMC QA Mr. Shen Xue Jun informed Caltrans QA the VT of tack welds was performed by ZPMC QC on the night shift. The slag inclusion was shown to ZPMC Certified Welding Inspector (CWI) Mr. Gu Xin Hai. The inclusion was removed with light grinding and MT performed with no relevant indications noted. The PJP tack welds tested were found acceptable by Mr. Zhou Dongyun. Caltrans QA observed ZPMC QC technician Mr. Cai Xin Xin perform MT on three excavations of # 114.00 Skin C sub assembly MA 111 CJP longitudinal stiffener welds. Two of the excavations were located on weld # 8 and one was located on weld # 11. All three excavations were accepted by ZPMC QC Mr. Cai Xin Xin.

The Caltrans QA Inspector performed VT and MT examinations of the stiffener welds of #114.00 D sub assembly MA110 and # 114.00 Skin C sub assembly MA111. Inspector observed that testing and welding appeared to be in

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general conformance with AWS D1.5 2002 requirements.

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
