

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000585**Date Inspected:** 07-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Ye Jong Yun**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 77, 89 & 114**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 and Magnetic Particle Testing (MT) # 89.00 and 77.00, 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 Skin Plate B sub assembly MA102 Complete Joint Penetration (CJP) longitudinal stiffener welds after heat straightening. ZPMC QC Li Liming reported an unacceptable indication that measured 13 mm with a + 3 defect rating on weld # 6. Personnel and transducer angle of testing were as follows. Mr. Li Liming performed straight beam testing and 45 degree shear wave testing. Ms E Shuiqin performed 70 degree shear wave.

QA Inspector Viars witnessed ZPMC QC technician Mr. Cai Xin Xin performing MT on Mock-up # 89.00 Skin Plate B weld # 4 and 5 Partial Joint Penetration (PJP) root pass. The digital picture below illustrates Mr. Cai Xin Xin performing MT of # 89.00 Mock-up Skin B.

Caltrans QA witnessed Mr. Zhou Dongyun perform MT of Mock-up # 77.00 D connection plate PJP pass on welds 11, 12, 13, 14, 15, 16, 17 and 18. Mr Dongyun also performed MT of Mock-up # 89.00 MP510 to MP512 and MP511 to MP512 tack welds. Mr. Dongyun found the above mentioned tack welds to be in conformance with AWS D 1.5 requirements.

The Caltrans QA Inspector monitored Ultrasonic examinations of Mock-up # 114.00 and Magnetic Particle

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testing of Mock-up # 77.00 and # 89.00. 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.

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
