

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-000586**Date Inspected:** 04-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Hau Li Wei**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:** 77 D & 114 A,C**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 Visual Testing of Mock-up # 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 longitudinal stiffener Complete Joint Penetration (CJP) welds Skin A MA107 and MA112. The following results were reported By ZPMC Quality Control (QC) technicians, # 114.00 sub assembly MA107 unacceptable indication measuring 30 mm reported on weld # 3 sub assembly MA107 two unacceptable indications of 30mm and 20mm were recorded by ZPMC QC, Ultrasonic Testing was performed by ZPMC certified UT technicians Mr. Li Liming and Ms. E Shuiqin. Mr. Liming performed straight beam testing and 45 degree shear wave testing. Ms. E Shuiqin performed 70 degree shear wave testing.

Caltrans QA Inspector requested Bureau Veritas QC Mr. Hau Li Wei to perform visual inspection of Mock-up # 77.00 connection plate tack welds. Mr. Hau Li Wei stated that the tack welds were not in conformance with AWS D1.5 requirements. Numerous areas of weld spatter, overlap, areas at the ends of tack welds were not transitioned. The following picture illustrates tack welds prior to repair. Mr. Wei requested the areas be repaired and Magnetic Particle Testing be performed.

The Caltrans QA Inspector monitored Ultrasonic examinations of Mock-up # 114.00. QA Inspector observed that the testing appeared to be in general conformance with AWS D1.5 2002 requirements.

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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
