

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-000646**Date Inspected:** 15-Oct-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:	Fu Guo Gan	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:	OBG Closed Rib Trial	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the dimensional testing of Orthotropic Box Girder (OBG) 10 Meter Mock-up closed rib trial, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

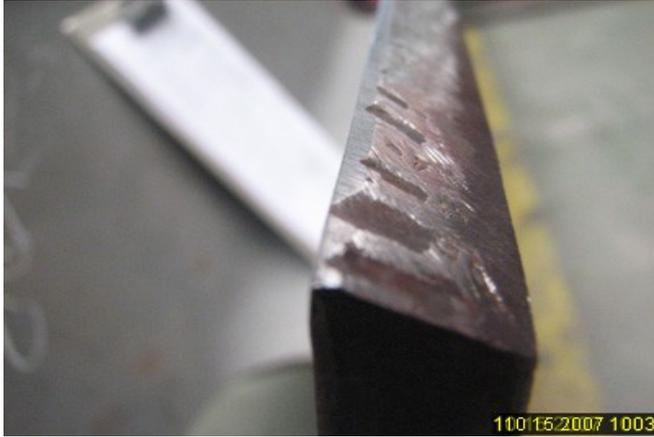
Caltrans QA Inspector performed dimensional measurements of closed rib bevel land of 10 meter mock-up rib # 70, 71, 74, 102 and 104. Measurements were taken starting at hand hole side with a starting measurement of 1 meter and increases in 1 meter increments ending at 9. The following bevel land measurements of each closed rib were recorded. Closed rib # 70, had a minimum of 1.5 mm, and a maximum of 2.0 mm. Closed rib # 71 had a minimum 0.7 mm, with a maximum of 2.3 mm. Closed rib # 74 the recorded minimum was 1.4 mm with a maximum of 1.8 mm. Closed rib # 102 the recorded minimum was 0.00 mm with a maximum of 1.9 mm. Closed rib # 104 the recorded minimum was 1.6 mm with a maximum of 2.2 mm. Closed Rib # 102 (W5) the minimum measurement was located at an area 30 mm long that appeared to be gouges from machining. The following picture below is of the gouged area on closed rib # 102. Measurements of the bevel land were taken with an optical comparator.

Caltrans QA Inspector performed bevel land measurements of the above mentioned closed ribs. Caltrans QA observed ZPMC Quality Control QC performing dimensional measurements of 10 meter closed ribs.

Caltrans QA Inspector observed that dimensional testing appeared to be in general conformance with AWS D1.5 2002 requirements.

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Summary of Conversations:

No relevant conversations occurred.

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
