

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-000696**Date Inspected:** 11-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:** Shanghai, China**CWI Name:** Xu Jun**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 77, 89 and 114 & OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77, 89 and 114 meters elevations scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

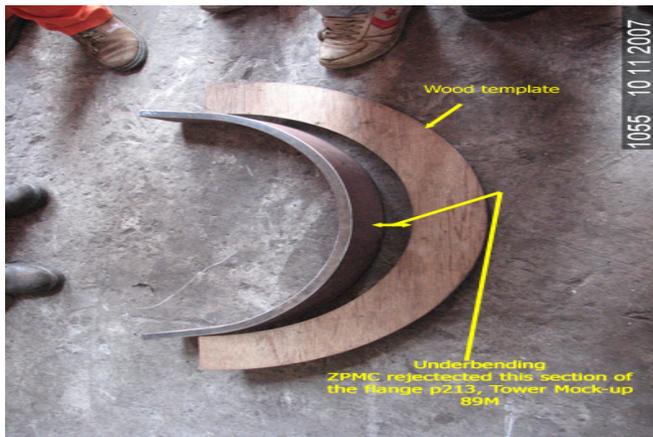
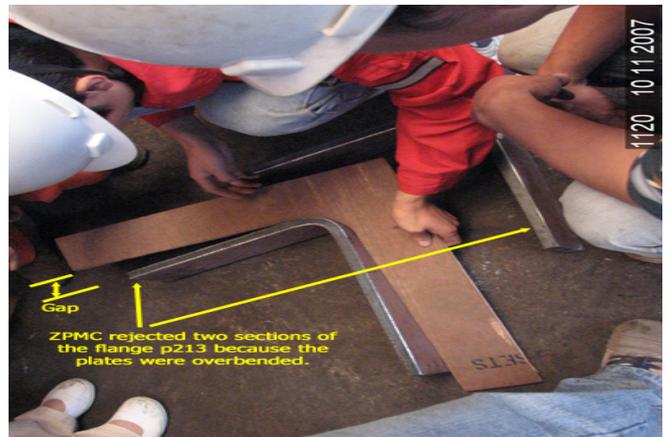
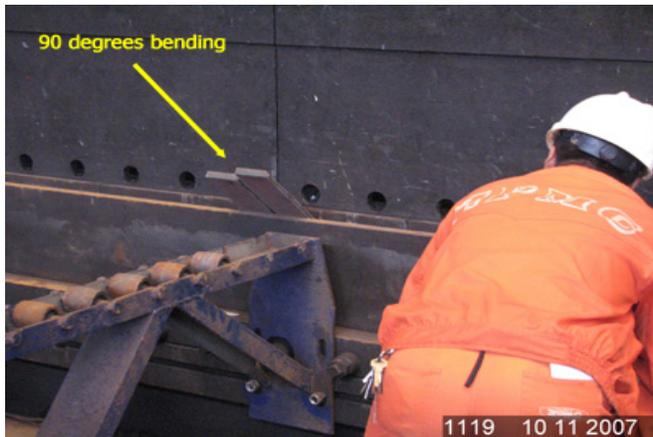
Tower Splice Mock-up 114 Meter Elevation

The QA inspector observed ZPMC performing weld repairs at the weld joint # 1 and 2, from the B side, at the internal corner plate A-116.

Item	Description	WBS	Dwg No.	Status
4	Cold Bending of the Flange p213 Tower Mock-up 89 Meter Elevation. The QA inspector witnessed the cold bending for the flange p213. This flange would be connected to the diaphragm plate SA-13. Just before the bending start, the QA inspector brought to the attention of the ABF representative Mr. Danny McDonald that the edges of the plates were not ground round 2 mm as per Special Provisions. Mr. McDonald agreed and requested to ZPMC QA representative Hu Gang that the edges needed to be bended as per special provisions. ZPMC ground the edges of the plates and bent the 3 sections of the components of the flange. ZPMC rejected the three sections because under bending and overbending of the plates. The photographs below show the plates when ZPMC was grinding the edges, during bending and when ZPMC was checking dimensions with the templates. The QA inspector performed random dimensional verifications of the plates (three sections P213) and ZPMC's templates before bending, and appeared to be in compliance with the contract documents.			

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- 5 Drilling and Cutting Tower Mock-up 114 M and 89 M.
The QA inspector observed ZPMC performing machining operations at the bevels for the Tower Mock-up 89 M and performing drilling operations on the Tower splice Mock-up 114 M piece marked MUC-A61.

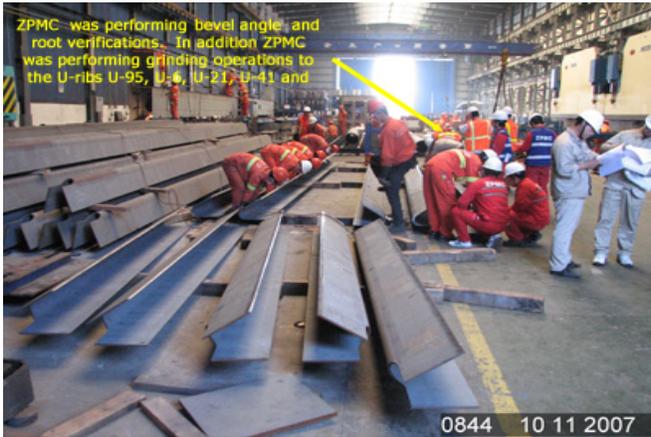
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6 OBG Weld Trial U ribs

The QA inspector observed that ZPMC was performing grinding operations at the U ribs U-95, U-6, U-21, U-41 and U-3. The QA inspector performed preliminary random verifications of the bevel angle and the root faces.



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