

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-000742**Date Inspected:** 30-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xianping & Ye Yong 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:	Caltrans Mockup/OBG	

Summary of Items Observed:

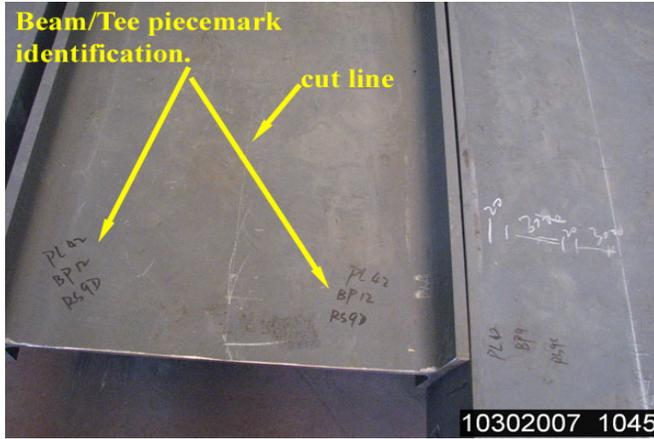
Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	OBG	NA	NA	Work in Progress

Orthotropic Bridge Girder (OBG) Building #2: Caltrans QA Inspector observed ZPMC oxy-fuel flame cutting diaphragm plates using the computer numerical control (CNC) cutting process at Mockup Shop, building #2. The material is identified as 12mm X 2900mm X 15400mm; piecemark number X14-X14A 1, identification number NG070513G044, batch number 072013730502, material type A709M 345T2-X, and piecemark number X15-X15A 2, identification number NG070513G045, batch number 072013740101, material type A709M 345T2-X. Following digital pictures illustrate material identification and the oxy-fuel flame cutting of the plate in progress.

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|---|-------------|----|----|------------------|
| 4 | Flange Ring | NA | NA | Weld 4 backgouge |
|---|-------------|----|----|------------------|
- Mock-Up 77M, Flange Reinforcement Ring Assembly: Caltrans QA Inspector observed the assembly being positioned at the workstation for future welding of the splice welds. The assembly is identified as having five complete joint penetration (CJP) welds that will be welded out in the vertical position. ZPMC is presently welding alignment aids around the assembly to hold it in position while welding the CJP welds. These welding aids are being welded to a platform type work-table which the ring assembly is setting on.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
