

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-000750**Date Inspected:** 31-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:** Art Peterson**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 Trail**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the dimensional testing of Orthotropic Box Girder (OBG) 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 witnessed American Bridge Flour (ABF) QC Mr. Art Peterson performing random dimensional measurements of Closed Rib Weld Trial tack weld length and spacing as well as fit-up gap. ZPMC Quality Control (QC) personnel performed dimensional measurements prior to ABF QA and Caltrans QA measurements.

Caltrans QA Inspector Viars performed random measurements of Closed Rib weld Trial rib to deck plate root gap. The maximum gap noted was 0.75 mm located on closed rib # U01, weld # 4. A summary of U-Rib gap measurements are as follows, U-Rib 73 - 3 locations at or over 0.5 mm with a maximum of 0.65 mm, U-Rib 01 - 5 locations at or over 0.5 mm with a maximum of 0.75 mm, U-Rib 75 - 2 locations at or over 0.5 mm with a maximum of 0.75 mm, U-Rib 02 - 3 locations at or over 0.5 mm with a maximum of 0.6 mm and U-Rib 05 - 1 location over 0.5 mm which measured 0.68 mm. Measurements were taken prior to camber. The following picture shows the filler gauge 0.75 mm inserted into U-Rib # 01 on weld # 4 between tacks 16 and 17.

Comparison of measurements taken from ZPMC and Caltrans of the tack weld length appeared to be similar with minimal deviation. Tack welds were blended and transitioned for root pass welding. A total of 17 tack welds were noted on each weld.

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Caltrans QA Inspector Viars performed random dimensional measurements of closed rib to plate fit-up, tack weld length and spacing.



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
