

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-000763**Date Inspected:** 23-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:** Lu Jian Hua**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 and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item	Description	WBS	Dwg No.	Status
1	Ultrasonic Testing (UT) to the weld repair at the Skin C weld joint # 5, 114 M The QA inspector witnessed ZPMC Quality Control inspector Mr. Li Li Ming performing UT at the junction of the skin C and longitudinal stiffener subassembly MA111, weld joint # 5. The QA inspector observed that after completion, Mr. Li Li Ming wrote on the steel that the weld repair area was acceptable. The QA inspector observed UT evaluations appeared to be in general compliance with the contract documents. Later, the QA inspector observed ZPMC re-scanning the weld repair area. ZPMC QA inspector Mr. Fu Yu Hong informed the QA inspector that after ZPMC re-evaluating the weld repair area, ZPMC determined that the weld repair area had a rejectable indication with approximately 30 mm of length.			

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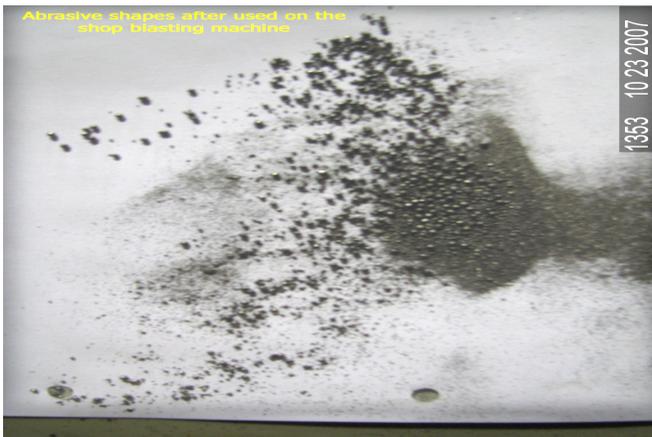
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2 Sand Blasting and painting on the W21x51 OBG Fabrication

The QA inspector visited the ZPMC paint shop. The QA inspector observed that ZPMC was blasting the surfaces of the shapes designated as W21x57 (shapes that ZPMC would use on OBG fabrication) thru two (2) shot blasting machine located on series. The surface obtained appeared to be in general compliance with blast profile SSPC-6 for commercial blasting. See digital photograph below. The QA inspector had a conversation with ZPMC QA inspector Mr. Xu Jun. Mr. Xu Jun relayed that the abrasive used for blasting the W shapes was made 1.5 mm diameter steel shots. See below the bag with the abrasive specification used by ZPMC and the primer coating (gray inorganic zinc) container. In addition, photos with ZPMC's paint and blast areas.

Note: ZPMC would coat the W shapes with the intent of protecting the parts for corrosion during storage.



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3 Tower Mock-up 114 M, Heat straightening at the corner plate A-116

The QA inspector witnessed the heat straightening for the corner splice designated as A-116. The QA inspector observed that the heat straightening report HRS-(CT)-008 from ZPMC was approved by Caltrans representative Ady Velasco on 10/12/07. The QA performed random verifications of the ZPMC's heat straightening operations at the A-116 corner splice. The QA inspector found that the heat straightening operations appeared to be in general compliance with the contract documents.



4 Tower 89 Meter Elevation Milling operations

The QA inspector observed ZPMC performing milling operations to the bevels before fitting operations at the skin panel E, subassembly MA38 plate mp502. The photograph below shows the skin E during milling operations at the bevel preparation.

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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
