

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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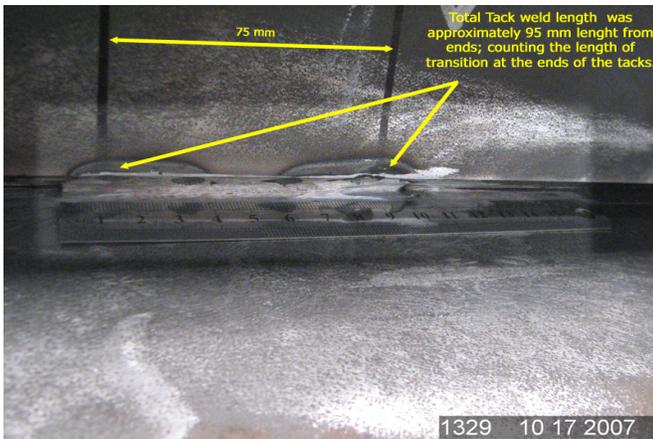
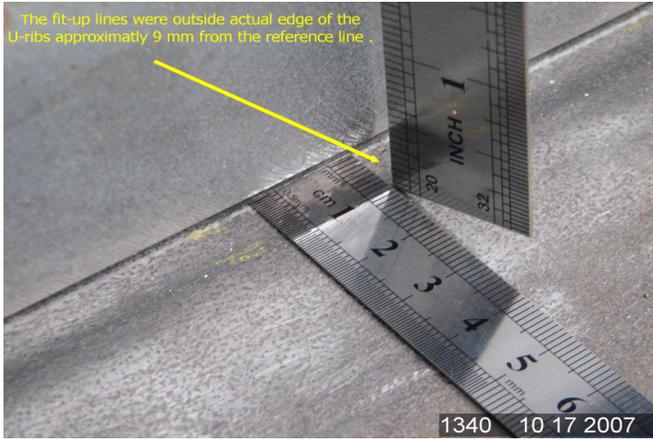
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000771**Date Inspected:** 17-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime 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:** OBG weld trial**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the 10 meters U-ribs Weld Trial scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector was at the OBG mock-up performing fit-up verifications on the weld Trial as schedule per ZPMC. The QA inspector performed random verifications of the gaps between the deck and the U-ribs, and tack welds locations, length and effective throat for the U ribs U-70, U-74, U-102, U-104 and U-71. The QA inspector observed that the gaps measured between the deck and the U-ribs appeared to be in compliance with ZPMC fabrication procedure. In addition, tack welds were located at 50 mm from the ends and with 15 spaces of 600 mm and one space of 880 mm between centers; tack welds length were approximately 75 mm and the effective throat was measured approximately from 6 to 7 mm. The QA inspector had a conversation with ABF representative Mr. Peter Ferguson, Mr. Ferguson relayed that the Caltrans's dimensional inspection have been postpone for 2 hours because ZPMC needed to take some more dimensions and recorded them on the steel. At approximately 1345 hours ZPMC completed with their verifications and Caltrans dimensional verifications were still in progress at the end of the shift. The digital photographs below depict some of the dimensional inspections performed by the QA inspector and ABF and ZPMC representative's meeting after the QA inspector point out to ABF representative Mr. Peter Ferguson minor dimensional discrepancies.

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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