

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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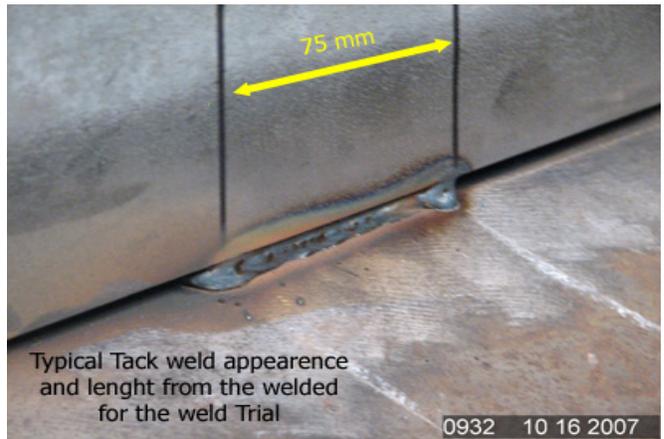
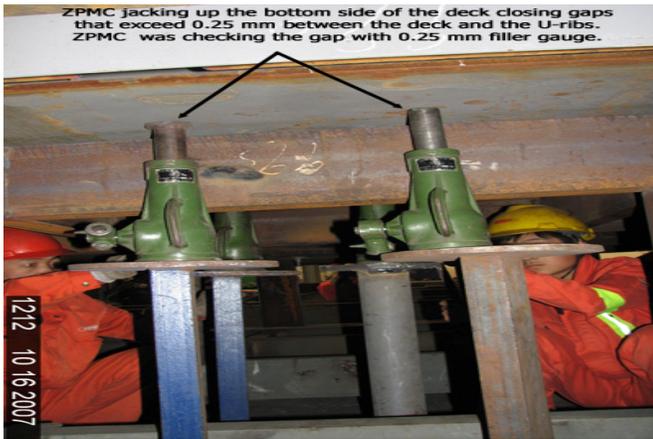
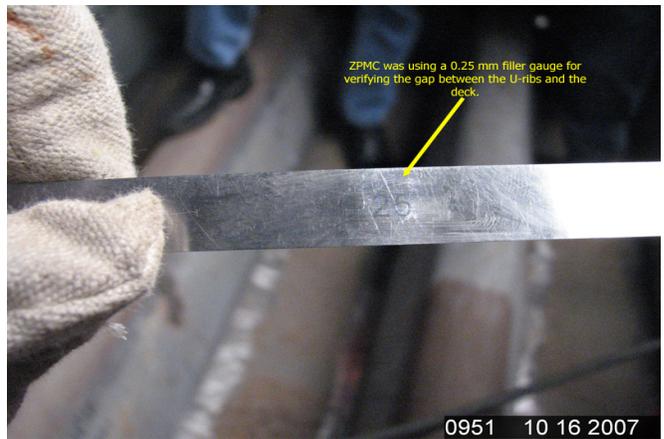
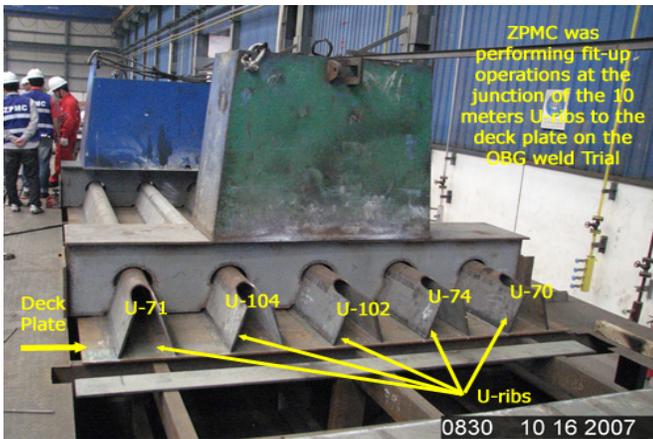
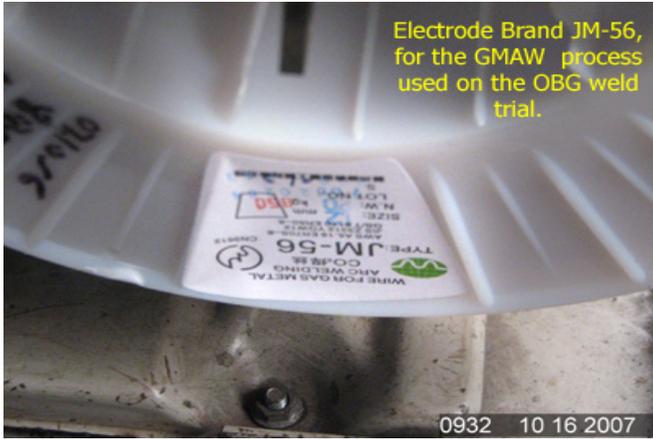
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000772**Date Inspected:** 16-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime 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:** Fu Guogang**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 at the junction of deck to u-ribs U-70, U-74, U-102, U-104 and U-71. The QA inspector performed random verifications of the gaps between the deck and the U-ribs, tack welds spacing and length. The gaps between the deck and the U-ribs appeared not to exceed 0.25 mm. The QA inspector had a conversation with the ZPMC QA inspector Mr. Fu Yu Hong. Mr. Fu relayed that ZPMC was intended to closed the gap down to less than 0.25 mm because ZPMC was expecting that the gaps would open after the pressure from the weights (2.5, 10 and 2.3 Metric Tons) were release. The QA inspector observed welder Yang Yong Zheng performing tacking operations with the Gas metal arc welding (GMAW) process. The QA inspector verified the welding parameters. The QA found that the welding parameters appeared to be in compliance with the welding procedure specification (WPS)-B-T2342 U2 (Uribs). The digital photographs below show the fit-up activities performed by ZPMC on this date.

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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
