

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-003978**Date Inspected:** 21-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan 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 and Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Production Monitoring Test (PMT) for Orthotropic Box Girder (OBG) Deck panels and fabrication of Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Sub Assembly Shop Bay 1:

Gantry 2 / PMT 1

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP335-001. The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. A Visual inspection of the root pass and cover pass was performed by ZPMC, American Bridge Flour (ABF) and the Caltrans QA. The Caltrans QA observed ZPMC QC Xue Hai Rong perform Ultrasonic testing of the Partial Joint Penetration weld for depth of penetration. Mr. Xue found the depth of penetration of the PMT welds to be in compliance with contract documents. The Caltrans QA inspector designated locations for Macroetch samples (15 locations). Macroetch samples were evaluated with a 7x optical comparator and accepted by ZPMC QC, ABF QC and The Caltrans QA Inspector.

Heavy Machinery Shop Bay 2:

The Caltrans QA Inspector was informed by swing shift QA Inspector Ken Riley that a Critical weld repair was

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being performed on the 33 meter Diaphragm web plate piece mark P832. The web plate was fabricated 20 mm shorter than the required length. ZPMC welder stencil #053753 was observed depositing Shielded Metal Arc Welding (SMAW) passes in the vertical position to build up the base metal required dimension. ZPMC did not complete welding during the night shift. Welding appeared be conformance with the posted Welding Procedure Specification WPS-485-SMAW-3G (3F)-Repair. Please see the attached photo below of ZPMC performing the above mentioned welding.

No other activities observed.



Summary of Conversations:

Only general conversations between QA and QC occurred this date.

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 Ady Velasco 138 1694 2685, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Lanz,Joe	QA Reviewer
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