

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-004043**Date Inspected:** 26-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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 Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: Mr. Sun Bo

Heavy Bay #3:

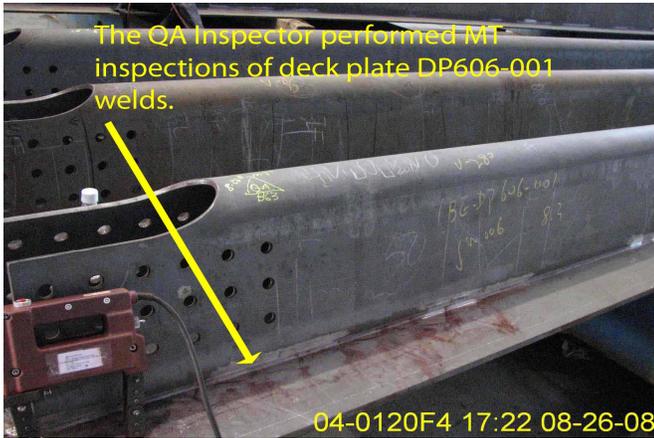
Around 1500 hours ZPMC QC Inspector Mr. Sun Bo informed the QA Inspector that he and ABF Inspector Mr. Ding Bao hua have accepted final visual inspections of the welds of deck panels DP606-001 and DP594-001 in heavy bay #3 and they are ready for QA visual inspections. The QA Inspector observed two welds in DP606-001 had weld overlap that had been previously marked but not completely removed. Following removal of the overlap and QC acceptance of the weld overlap the QA Inspector determined the two deck panels appear to comply with project specifications and the QA Inspector documented the visual inspections on the yellow inspection status tag that is attached to each of the deck panels.

ZPMC QC Inspector Mr. Sun Bo informed the QA Inspector that he and ABF Inspector Mr. Ding Bao hua have performed initial visual inspections of the welds of deck panel DP546-002 in heavy bay #3 and they are ready for QA visual inspections. The QA Inspector marked a few additional areas of weld overlap. QA Inspector documented the initial visual inspections on the yellow inspection status tag that is attached to the deck panel.

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ZPMC notification of witness inspection document #00920 dated 8-26-2008 states that ZPMC QC inspection personnel will be conducting final magnetic particle inspections of the closed rib welds on deck plate DP586-001, DP616-001, DP297-001, DP594-001, DP606-001 and DP548-002. Following ZPMC performing magnetic particle inspections, the QA Inspector performed random magnetic particle inspections of welds on the deck panels listed above and items observed appear to comply with project specifications. The QA Inspector documented these visual inspections on the yellow "SFOBB QA Verification In Process" tags attached to each of the deck plates adjacent to where ZPMC and ABF Inspectors had documented their inspections. See the photograph below and the TL6028 MT test report for additional information.



Summary of Conversations:

See 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 Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
