

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-004050**Date Inspected:** 03-Sep-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:	NA	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:

Bay #3

The QA Inspector performed AWS D1.5 ultrasonic inspection of completed welds on "H" shape splice welds on side plate welds SP125-001-039-, -040, -047, -049, base plate welds BP144-001, -002, -019, -021, BP036-001, -002, -005, -006, -019, -021, -027, and -029. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

Bay #7

The QA Inspector performed AWS D1.5 ultrasonic inspection of completed welds on floor beam welds FB032-001-125, -126 and FB029-001-148. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

Bay #8

The QA Inspector performed AWS D1.5 ultrasonic inspection of completed welds on

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tower diaphragm welds WSDI-SA290-5A/B, -6A/B. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

The QA Inspector observed tower diaphragm WSDI-SA309 welds 3, 4, 5, 7, 8, 9, 10, 11 and tower diaphragm welds WSDI-SA248-3, 4, 5, 6, 7, 8, 9 and 10 which were ultrasonically inspected by ZPMC personnel yesterday are now being welded to other plates. The QA Inspector did not perform ultrasonic inspections of any of these welds due to limited access and that the welds were hot due to having been preheated prior to welding.



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