

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004051**Date Inspected:** 04-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 #7

The QA Inspector performed AWS D1.5 ultrasonic inspections of floor beam complete joint penetration welds FB003-041-044, FB003-041-032, FB010-012-026, FB010-013-026, FB015-022-026, FB059-003-001, FB059-003-095, FB059-003-096, FB059-008-001, FB059-008-095, FB059-008-096, FB059-006-001, FB059-006-095, FB059-006-096, FB059-002-001, FB059-002-095 and FB059-002-096 following ZPMC performing/accepting UT inspections of these welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

The QA Inspector performed AWS D1.5 ultrasonic inspections of OBG diaphragm complete joint penetration welds SSD15-PP043-131 and SSD12A-PP046-006 following ZPMC performing/accepting UT inspections of these welds. Note: ZPMC is required to perform UT inspections of 25% of the length of all the welds and ZPMC completed UT inspections of 100% of the length of 1 of every four welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

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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
