

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-004057**Date Inspected:** 12-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:

Assembly bay 1:

ABF representative Mr. Kevin Dye had informed QA that SP602A / 5BE is ready for QA green tagging. ZPMC QC has previously visually accepted these welds. ZPMC workers removed the rust from two of the welds to allow the QA Inspector to perform magnetic particle inspections of the welds. The QA Inspector performed random visual inspections of various welds on SP602A and observed some of the welds have undercut and overlap. The QA Inspector showed ZPMC representative Mr. Lei Tau the visually rejectable welds and Mr. Tau said the welds will be repaired. See the photographs below for additional information.

The QA Inspector performed random magnetic particle inspections of side plate EP5A stiffener welds. This side plate has been presented to QA for final green tagging. Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

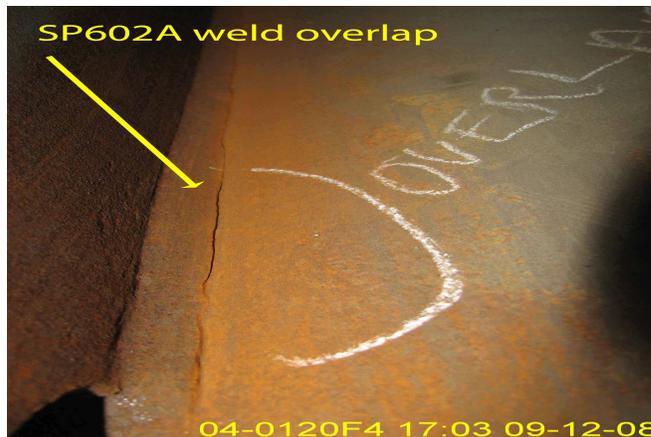
Bay 3

The QA Inspector performed random AWS D1.5 ultrasonic inspections of OBG H shape (stiffener) splice welds

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SP126-001-037, -038, -051, -053; SP339-001-037, -038, -051, -053; SP336-001-037, -038, -051, -053; SP153-001-037, -038, -051, -053; SP099-001-043, -062, SP312-001-043, -062. Items observed appear to comply with project specifications. See the TL6027 ultrasonic 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
