

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-004093**Date Inspected:** 26-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

QA Inspector reviewed ABF and ZPMC QC accepted radiographic (RT) film for deck plate complete joint penetration (CJP) welds. Radiographic film for welds reviewed were; DP94-001-117, DP536-001-189, DP227-001-189, and DP146-001-189. RT film for deck plate welds appear to be acceptable to AWS D1.5 (2002) and special provisions. For details please see radiographic film report TL-6029 dated 26 September, 2008.

OBG Bay 1: Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panel DP411-001. 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 QC Inspector Chen Xi, American Bridge Flour (ABF) QC Inspector Wang Zhenhua, and QA Inspector. QA Inspector observed ZPMC QC UT Technician Ma Jilong perform Ultrasonic testing of the Partial Joint Penetration weld for depth of penetration. QC UT Inspector found the depth of penetration of the PMT welds to be in compliance with contract documents. QA inspector designated locations for Macroetch samples at 15 locations which included 4 tack welds). Macroetch samples were evaluated with a 7x optical comparator and accepted by ZPMC QC, ABF QC and The Caltrans QA Inspector.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

No significant conversations this day.

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 Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
