

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-004123**Date Inspected:** 13-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Liang**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:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate "D"	NA	NA	QAMT

Tower

Heavy Shop 1: Caltrans QA inspector performed MT/10% inspection at skin plate "D", longitudinal stiffeners cover pass welds identified as weld ESD1-SA296A/E, 11, 12, 13, 14, 15, 16, 17 and 18. Caltrans QA inspector tested 5 meters at each weld. During Swing Shift, shift change. Mr. Paul Dawson stated, he performed random visual inspection and observed places on the welds for welding pick-ups, and the regrinding of the weld access holes on the longitudinal stiffeners. Mr. Dawson thought that ZPMC might complete this rework and present to Caltrans QA night shift for reinspection. This rework was not completed by ZPMC. ZPMC QA inspector, Mr. Shen Xue Jun informed Caltrans QA inspector that this reinspection of skin plate "D" would be presented to Caltrans at future date for reinspection. The welds MT inspected appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated October 13, 2008 for additional information. The following digital pictures illustrate tower skin plate "D" subassembly and QAMT inspected weld #11.

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

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 Joshua Ishibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer