

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004126**Date Inspected:** 10-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:** Li Yang**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	Tower (Southside) Skin Plate C	NA	NA	QAMT

Tower Shop

Heavy Duty, Bay 1: Caltrans QA inspector performed magnetic particle testing (MT) per ZPMC notification of witness inspection for green tag, document number 001175, dated October 10, 2008. The subassembly is identified as South Tower Skin Plate C. In Bay 1, Caltrans QA Inspector met with American Bridge/ Fluor (ABF) Quality Control (QC) inspector, Mr. Zhang Qin Jian. Mr. Zhang Qin Jian stated ZPMC QC completed its MT inspection and acceptance of the welds joining longitudinal stiffeners to skin plate. Caltrans QA inspector observed that ZPMC MT inspected three meters of each weld identified as SSD1-SA117A/G, weld 39 & 40; SSD1-SA117A/G, weld 36 & 38; SSD1-SA117A/G, weld 35 & 37; SSD1-SA117A/G weld 33 & 34; SSD1-SA117A/G weld 31 & 32; SSD1-SA117A/G weld 29 & 30 and SSD1-SA117A/G weld 27 & 28. Caltrans QA inspector performed ten-percent QAMT inspection of each weld cover-pass. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated October 10, 2008 for additional information. The following digital pictures illustrate inspected subassembly Tower Skin Plate "C" subassembly.

