

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-004150**Date Inspected:** 17-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:****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 Tower	NA	NA	QAMT
Heavy Shop 1: Caltrans QA inspector performed MT/10% inspection at Lift 2 tower skin plate "D", plate splice identified as weld SSD1-SA208A/D-13, SSD1-SSD1-SA208A/D-25, SSD1-SA208A/D-9, SSD1-SA208A/D-3, SSD1-SA208A/D-11, SSD1-SA208A/D-14, SSD1-SA208A/D-15 and Skin Plate C, NSD1-SA179B/E-11B. The QAMT coverage was approximately 10% of each weld cover-pass. The welds were found to be in compliance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated October 17, 2008 for additional information.				
2	Tower Diaphragm Plate	NA	NA	QAMT
Bay 8: Caltrans QA inspector performed magnetic particle (MT) inspection per ZPMC notification of witness inspection, document number 001223. The subassembly is identified as Tower Diaphragm 65M, plate splice weld, ESD1-SA415-1A cover-pass. The QAMT coverage was approximately 10%. The welds were found to be in compliance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated October 17, 2008 for additional information. The following digital picture illustrates the inspected diaphragm plate subassembly.				

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
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Reviewed By:	Cuellar, Robert	QA Reviewer
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