

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-004206**Date Inspected:** 27-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao**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 Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher 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:

OBG Assembly Bay II

Deck panel U-rib crack repairs continue in multiple locations

NPI of Portland, Or. perform phased array on multiple deck panels for crack detection in the U-rib to deck panel partial penetration joints..

No diaphragm plate to deck panel installation occurring either in the mid bay or north side bay.

5AW- Welding operations performed at LD002-03 welds to bottom plate BP137 in the 2G position. Welders seen utilizing both slag hammer and wire brushes. QA observed preheating to 65 Celsius. QA measured the heat applied and found it to be under the r5equred preheat requirement. However welder He Junrong measured with a temp gun and re-applied heat by flame torch and established the minimum required preheat.

4BW- Arc gouging and removal of run off tabs at ssd11 panel point 27

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3AW- QA observed joint prep examination by ZPMC QC personnel for stiffener location at ssd12 panel point 22 by inspector Zhao Cheng Jian.

OBG North Bay- Joining by SAW deck panels DP108-001 and DP81A-001

Base metal build up by FCAW in 2G position at edge panel edge EP39A. QA observed that possibly not enough temperature indicators (Tempilstiks) and/ or IR thermometers are available to the OBG QC or welding personnel.

The above mentioned items as observed, corrected by contractor QC & documented by QA appear to conform to the contract documents.

Summary of Conversations:

No relevant conversations this date.

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 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
