

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-004241**Date Inspected:** 14-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	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 Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, 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:

Heavy Bay 3.

ZPMC QC representative Mr. Testino informed QA personnel that ZPMC and ABF are going to perform initial visual inspections of closed rib welds on deck panels DP541-001, DP576-001 and DP611-001. The QA Inspector performed random visual inspections of DP576-001 and DP611-001 and the QA Inspector observed a few additional areas of weld overlap which the QA Inspector marked as needing to be repaired. The QA Inspector documented the initial visual inspections on the yellow ABF tracking tag that is attached to each of the two deck panels. The QA Inspector observed ZPMC CWI Mr. Soapy Shi performing visual inspections of deck panel DP541-001 and later in the shift the QA Inspector observed one of the welds on DP541-001 has paint on the weld and adjacent base material and that this weld does not appear to have been visually inspected by Mr. Shi. The QA Inspector informed Mr. Testino that DP541-001 has paint on portions of the weld and adjacent base material. Mr. Testino said this paint might have been installed to prevent rusting of the weld and that the paint will need to be removed prior to completion of the visual inspections.

OBG Assembly Bay #2

WELDING INSPECTION REPORT

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The QA Inspector performed ultrasonic inspection of completed welds on deck panel DP070-001 to locate potentially cracked tack weld locations. QA observed 10 of 75 welds that this Inspector inspected require additional evaluations with the phased array ultrasonic technique to determine if the welds contain cracks. The other welds on this deck panel were ultrasonically inspected by QA Inspector B102.

Summary of Conversations:

See above.

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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
