

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-004249**Date Inspected:** 24-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:

OBG Bay 7

ZPMC representative Mr. Shen Hue Jun informed the QA Inspector that ZPMC QC inspection personnel will be conducting magnetic particle inspections of OBG welds on floor beams FB011-010 and FB009-013 today.

The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of OBG floor beams welds:

FB011-010- 004, 010, 013, 014, 022, 023, 031, 032, 037, 038, 039, 040, 047 and 048.

FB009-013-004, 010, 013, 014, 022, 023, 031, 032, 037, 038, 039, 040, 047 and 048.

ZPMC Inspection personnel had previously visually & UT inspected and accepted these welds. Items observed appear to comply with project specifications. See the TL6028 magnetic particle test report for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG Assembly Bay

ZPMC representative Mr. Shen Hue Jun presented the QA Inspector with a welding repair report B-WR1009 stating that ZPMC is going to removed diaphragm plate on DP007-001 due to having two cracked tack welds that appear to have propagated into the base material. Caltrans QA Task Leader Mr. Albert Carreon consulted with Caltrans Engineer Mr. Peter Dautermann who directed that ZPMC should issue a critical weld repair prior to removal of the diaphragm plate. The QA Inspector informed ZPMC QC Representative Mr. Testino of Mr. Dautermann's decision and Mr. Testino said ZPMC is going to proceed with the removal of the diaphragm plate using welding repair report B-WR1009. The QA Inspector issued an incident report that documents the removal of this diaphragm plate and related welds.

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 Peter Dautermann 150-0219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------