

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-004250**Date Inspected:** 25-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 have completed magnetic particle inspections of OBG welds on floor beams FB016-019 and ZPMC needs to move this floor beam out of bay 7 as soon as possible.

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

FB016-019-004, 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. The QA Inspector observed fillet weld FB016-019-022 was approximately 1 mm undersize for a length of 100 millimeters. The QA Inspector informed ZPMC CWI Mr. Liu Wei Wei who had the weld repaired. The QA Inspector also observed weld FB016-019-029 had overlap at the bottom toe of the weld. Mr. Liu Wei Wei had a ZPMC worker use a grinder to blend the bottom edge of this weld. Following completion of the repairs, the QA Inspector determined

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items observed appear to comply with project specifications.

OBG Bay 3

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

SP443-001-001, 003, 005, 007 and 009. No lot number was assigned to the tagging document due to Caltrans needing to perform UT inspections of the stiffener splice welds.

SP613-001- 014, 018, 020, 022 and 024. The QA Inspector assigned lot number B63 to the tagging document.

ZPMC Inspection personnel had previously visually & UT inspected and accepted these welds. Items observed appear to comply with project specifications.

OBG Bay 8

The QA Inspector performed random AWS D1.5 visual and magnetic particle inspections of tower component ESD1-SA422 weld 4 and 6 welds:

ZPMC Inspection personnel had previously visually & UT inspected and accepted these welds. Items observed appear to comply with project specifications.

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
