

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-004373**Date Inspected:** 20-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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:	Zhu Hang Hai		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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:**

Summary of Items Observed: Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform random inspections of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Heavy Machinery Bay 1:

The Caltrans QA inspectors Steve Hall and Larry Viars were requested to perform VT and MT testing of ZPMC tested and accepted South Tower Skin D longitudinal stiffener connection plate PJP welds. During VT areas of overlap, slag inclusions, and areas that appeared to be cracked were found. Three welds were chosen to MT all three welds had rejectable indications. These areas were shown to Mr. Mike Williams with ABF. Mr. Williams stated that ZPMC would perform visual and MT again and ABF would perform visual testing. See the attached photo below of the South Tower connection plate PJP weld SSD1-SA180 A/E weld # 10 transverse crack. An incident report was submitted for task leader review.

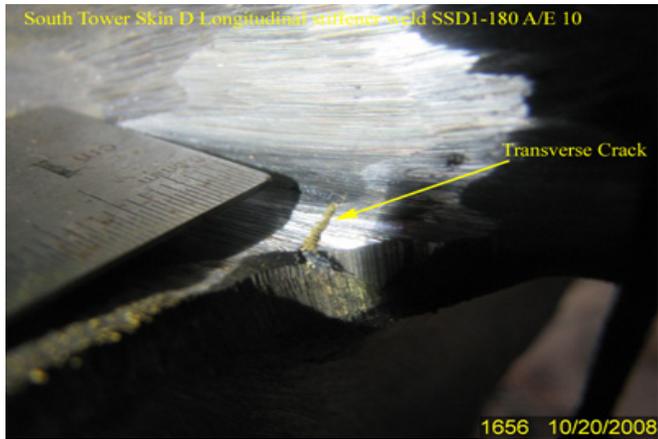
Heavy Bay 3:

Caltrans QA performed MT verification of ZPMC inspected and accepted Deck Panel U-rib welds of DP561-001, DP591-001, DP551-001 and DP546-001. No relevant indications were noted. Please see TL-6028 generated on this date for detailed information.

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Caltrans QA performed 3 party initial VT of DP380-001 along with ZPMC and ABF QC.



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 Joshaua Ishibashi, 137 6471 0411, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
