

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-004374**Date Inspected:** 22-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 and OBG**Summary of Items Observed:**

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

Sub assembly Bay 4:

The Caltrans QA performed MT verification and visual inspection of SP432A stiffener fillet welds SP432-001-001 through 010. After Verification MT and VT verification of stiffener welds Caltrans QA signed ABF documentation for green tagging along with ZPMC and ABF QC.

Heavy Machinery Bay 1:

Caltrans QA observed ZPMC welder Mr. Chen Xioayou performing Shielded Metal Arc Welding in the 2G position on connection plate welds previously rejected by Caltrans QA personnel for linear indications. ZPMC QC Mr. Zhu Zhong Hai was observed monitoring welding. Welding appeared to be in general conformance with weld repair welding procedure specification WPS-345+485-SMAW-2G(2F)-Repair. ABF representative Mr. Steve Lawton stated agreed a 48 hour hold time would be required for the 345 to 485 material repair.

Summary of Conversations:

As identified within the contents of this report.

WELDING INSPECTION REPORT

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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
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Reviewed By:	Wright,Mark	QA Reviewer
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