

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-004378**Date Inspected:** 28-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**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:** 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.

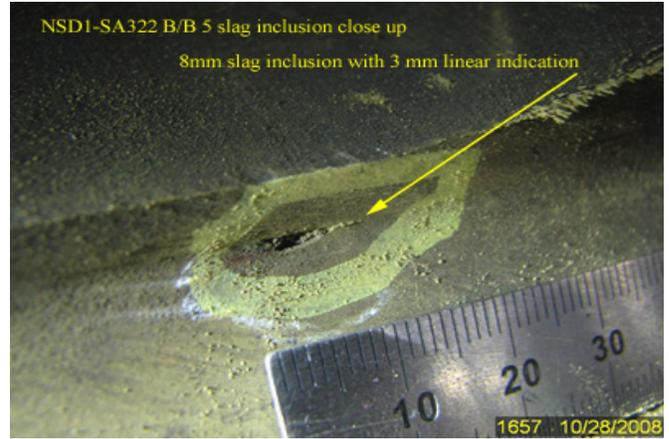
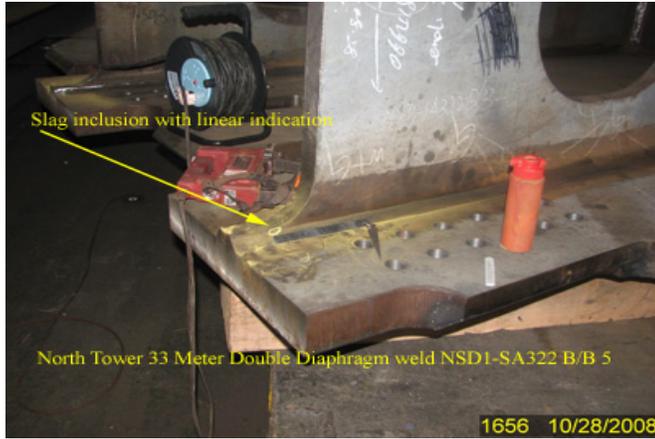
Caltrans QA performed VT and MT verification of the North Tower 33 Meter double diaphragm welds. During VT verification an 8mm slag inclusion was observed on the web plate to upper diaphragm PJP weld NSD1-SA322 B/B-5. MT was performed of the slag inclusion and a linear indication approximately 3 mm was observed. ZPMC stated that they would perform light blending of the indication to see if they could remove the linear portion. After blending QA observed that ZPMC had removed approximately 2 mm of the PJP weld at the stiffener to weld toe. QA performed MT of the excavation area and confirmed the indication was removed. ZPMC repaired the weld in accordance with repair welding procedure WPS-485-SMAW-2G(2F) and posted the time of repair and stated MT would be performed in 48 hours. See the attached photo below of the slag inclusion with linear indication below.

Caltrans QA performed MT and VT verification and signed green tag documentation along with ZPMC and ABF QC for SP577-001 welds 054 through 065, SP763-001 welds 043 through 054 and BP062-001 welds 001 through 011. Panels were located in Sub assembly bay 4

Caltrans QA performed MT and VT verification of FB003-076, FB003-085, FB003-091, FB003-090 and FB003-086 B side welds. ZPMC MT verification still needs to be performed on the A side of floor beams.

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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
