

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-004435**Date Inspected:** 27-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Diaph. Flange	NA	NA	QA-UT

OBG

Bay 4: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001295. The subassemblies are identified as Lift 2 tower diaphragm flange, weld SSD1-SA104A/B-9 and ESD1-SA425A/B-6. Caltrans QA inspector observed that the welds have been UT inspected and identified as accepted by ZPMC QC-MT inspector, Mr. Xu Rong Gang. Caltrans QA-UT coverage was approximately 100%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, October 27, 2008 for additional information. The following digital picture illustrates QA-UT inspection of weld ESD1-SA425A/B-6.

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2 Side Plates NA NA QA-UT
OBG

Bay 3: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001295. The subassemblies are identified as side plates, weld SP577-001-091, SP371-001-049, SP131-001-049, SP104-001-057, SP158-001-049, SP317-001-071 and SP344-001-049. Caltrans QA inspector observed that the welds have been UT inspected and identified as accepted by ZPMC QC-MT inspector, Mr. Jiao Jifeng. Caltrans QA-UT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, October 27, 2008 for additional information. The following digital picture illustrates QA-UT inspection of weld SP131-001-049.



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

Inspected By: Hasler, Mike

Quality Assurance Inspector

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Reviewed By: Cuellar,Robert

QA Reviewer