

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004449**Date Inspected:** 31-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**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 Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher 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 Assembly Bay II

Mid bay-

QA observed joint preparation for deck panels DP298 & DP325 prior to tack welding and final fit up. QA performed a cursory visual examination of the bevel surface area and the bevel angle which appeared to be smooth and has proper angle however QA observed base material discontinuity that will require a base metal restitution prior to fitting and tacking. ZPMC QC representative Wang Jie was available for this evolution and explained that a Welding Repair Report (WRR) would be generated for this issue.

QA observed heat straightening being performed at deck panels DOP198A & DP218A per ZPMC Heat Straightening Record HSR1 (B)-3437 Which recorded 3 millimeters as the deformation measurement.

QA was apprised by ZPMC QC personnel Fu You Shen of a crack in a tack weld at the 5BW side plate SP511A weld 345 directly adjacent to panel point 33 SSD11A. Fu You mentioned that grinding of the tack weld would commence immediately followed by Magnetic Particle (MT). which was due to stresses put on it when the

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stiffeners were aligned and set into place by hammer, pins and aligning plates.

The above mentioned items, as observed by QA and corrected by ZPMC QC appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

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 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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