

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-004511**Date Inspected:** 30-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:	NA	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 Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, 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 Bay #7

ZPMC notification of witness inspection document #01315 dated 10-29-2008 states that ZPMC inspection personnel will be conducting green tag ultrasonic (UT) inspections of OBG welds in OBG bay #7 today. See below for the weld numbers and the status of the welds that were observed by this QA Inspector today:

FB015-026-043: ZPMC has marked this weld as being UT accepted. The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of 10% length of this weld and items observed appear to comply with project specifications. The QA Inspector observed ZPMC and ABF have signed the yellow inspection status tag to indicate all ultrasonic inspections have been completed on the top side of this floor beam. This yellow inspection status tag has an identification number of 1321A, and the other side of the floor beam has an identification number of 1321B. The QA Inspector observed ZPMC personnel have previously performed ultrasonic inspections of weld FB015-026-023 and FB015-026-062 and the QA Inspector performed random ultrasonic inspections of these two welds and indicated lot number B63 on tag 1321A. Items observed appear to comply with project specifications.

FB016-027-045: ZPMC has marked this weld as being UT accepted. The QA Inspector performed random AWS

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D1.5 visual and ultrasonic inspections of 10% length of this weld and items observed appear to comply with project specifications. The QA Inspector observed ZPMC and ABF have signed the yellow inspection status tag to indicate all ultrasonic inspections have been completed on the top side of this floor beam. This yellow inspection status tag has an identification number of 1320A, and the other side of the floor beam has an identification number of 1320B. QA Inspector indicated lot number B63 on tag 1320A. Items observed appear to comply with project specifications.

FB011-015-043: ZPMC has marked this weld as being UT accepted. The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of 10% length of this weld and items observed appear to comply with project specifications. The QA Inspector observed ZPMC and ABF have signed the yellow inspection status tag to indicate all ultrasonic inspections have been completed on the top side of this floor beam. This yellow inspection status tag has an identification number of 1309B, and the other side of the floor beam has an identification number of 1309A. QA Inspector indicated lot number B63 on tag 1309B. Items observed appear to comply with project specifications.

ZPMC notification of witness inspection document #01311 dated 10-29-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of OBG welds in OBG bay #7 today. See below for the weld numbers and the status of the welds that were observed by this QA Inspector today.

The QA Inspector observed that ZPMC inspection personnel have completed ultrasonic (UT) inspections of floor beam welds FB024-003-117, FB024-003-122, FB020-003-117, FB020-003-122 in OBG bay #7 today. The QA Inspector observed ZPMC has marked these welds as being ultrasonically accepted and the QA Inspector also performed random ultrasonic inspections of approximately 10% length of each of these welds. Items observed appear to comply with project specifications.

ESD1-SA414AB-12AB and ESD1-SA414AB-14AB: ZPMC has marked these welds as being UT accepted. The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of approximately 25% length of weld ESD1-SA414AB-12AB and items observed appear to comply with project specifications. ZPMC had started to preheat weld ESD1-SA414AB-14AB and it was too hot to touch and the QA Inspector did not perform UT inspections of this weld.

ZPMC notification of witness inspection document #01313 dated 10-29-2008 states that ZPMC inspection personnel will be conducting ultrasonic (UT) inspections of OBG welds in OBG bay #7 today. See below for the weld numbers and the status of the welds that were observed by this QA Inspector today.

FB023-0057-0117 and FB023-0057-0122: ZPMC have marked these welds as being UT accepted. The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of 10% length of this weld and items observed appear to comply with project specifications.

OBG Bay #4

ZPMC notification of witness inspection document #01316 dated 10-29-2008 states that ZPMC inspection personnel will be conducting green tag ultrasonic (UT) inspections of OBG welds in OBG bay #4 today. See below for the weld numbers and the status of the welds that were observed by this QA Inspector today:

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ESD1-SA424AB-12AB and ESD1-SA424AB-14AB: ZPMC has marked these welds as being UT accepted. The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of approximately 25% length of these welds and items observed appear to comply with project specifications.

Summary of Conversations:

See above.

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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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