

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004691**Date Inspected:** 19-Nov-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:** Tower & OBG**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 | OBG Floor Beam Subassembly | NA | NA | QA-UT |

OBG

Bay 7: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001453. The subassemblies are identified as OBG floor beams, FB004-026, FB014-020, FB005-028, FB014-026 and FB011-013, complete joint penetration (CJP) welds FB004-026-043, FB014-020-043, FB005-028-043 & 044, FB014-026-044 and FB011-013-045. Caltrans QA inspector observed that the welds have been UT inspected and accepted by ZPMC QC. 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, November 19, 2008 for additional information. The following digital picture illustrates inspected weld FB011-013-045.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

| | | |
|----------------------|--------------|-----------------------------|
| Inspected By: | Hasler, Mike | Quality Assurance Inspector |
|----------------------|--------------|-----------------------------|

| | | |
|---------------------|-----------------|-------------|
| Reviewed By: | Cuellar, Robert | QA Reviewer |
|---------------------|-----------------|-------------|