

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-004927**Date Inspected:** 05-Dec-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:** Lui Yang**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 Orthotropic Box Girder and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Heavy Tower Bay 1:

Caltrans QA received notification to perform final MT of Lift 2 South tower Skin E stiffener welds. QA observed an excavation measuring 65mm in length and 5 mm deep on E3 stiffener weld SSD1-SA61 E/G-16. ZPMC stated that surface porosity was visually noted during MT and a gas pocket was found during grinding. ZPMC stated that a weld repair report will be issued for the repair and final MT and VT would be performed again 12-6-08.

ZPMC was in process performing MT on South Tower Skin B stiffener welds MT was not completed by the end of the shift.

Heavy Tower Bay 3:

Caltrans QA performed MT verification of ZPMC tested and accepted welds for Deck Panels, DP412-001 welds 1 through 10 and DP116-002 welds 1 through 8. No relevant indications were noted. Please see MT report TL-6028, generated on this date for further information.

Summary of Conversations:

WELDING INSPECTION REPORT

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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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
