

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-012400**Date Inspected:** 20-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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 and Tower	

Summary of Items Observed:

On this date CALTRANS OSM 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. This QA Inspector observed the following:

OBG Bays 1 through 9

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 1 through 9.

OBG Bays 13 and 14

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 13 or 14 and the majority of the overhead lights were turned off.

Tower Bays 10 and 11

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in Tower Bays 10 or 11.

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OBG Trial Assembly

This QA Inspector observed no ZPMC personnel appeared to be welding on Caltrans OBG components at the trial assembly yard. Several ZPMC workers were drilling bolt holes in various side and bottom plate stiffeners at the splice joint between OBG segment 6CE / panel point 46 and segment 7AE / panel point 47.

This QA Inspector observed ABF personnel performing magnetic particle inspections of temporary alignment weld removal areas on the edge of OBG segment 6AE adjacent to where OBG segment 5CE will be welded at a later time. ABF personnel identified two magnetic particle rejections, one with a length of 9mm at location Y=8730mm and one with a length of 8mm at location Y=13090mm. See the photographs below for additional information.

This QA Inspector and Caltrans QA Inspector Mr. Mike Hasler performed magnetic particle inspections of temporary alignment weld removal areas on the edge of OBG segment 6AE, near panel point 37 where ABF personnel had previously performed magnetic particle inspections. The following top deck plates were inspected: DP516A, DP300A, DP327A, DP354A, DP381A, DP408A, DP435A, DP462A, DP327A, DP489A and CA26A. The areas that were inspected appear to comply with project specifications, except for the two locations where ABF had previously identified linear indications in the base material. These temporary welds had been installed to align the top deck plates of OBG segment 6AE with OBG segment 5CE. These magnetic particle inspections were performed as an informational basis and no TL6028 Magnetic Particle Test Report was issued. See the photograph below for additional information.

Many of the ZPMC workers are not at work due to the Chinese New Year holiday.



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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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