

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-012403**Date Inspected:** 24-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 & 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.

OBG Trial Assembly

This QA Inspector observed no ZPMC personnel were welding on Caltrans OBG segments in the trial assembly area.

One group of ZPMC workers were drilling splice plate holes where OBG cross beam CB5 connects to OBG

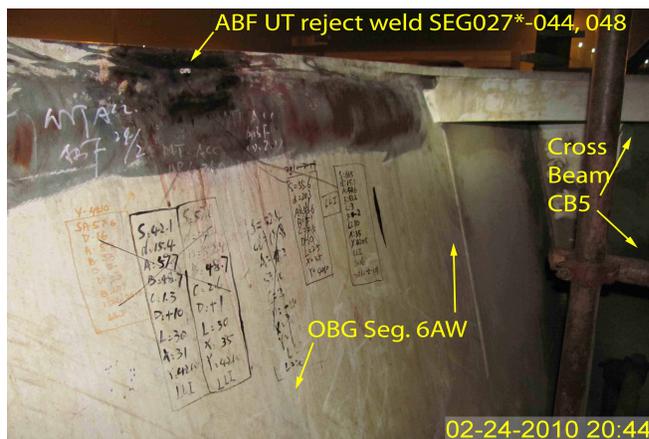
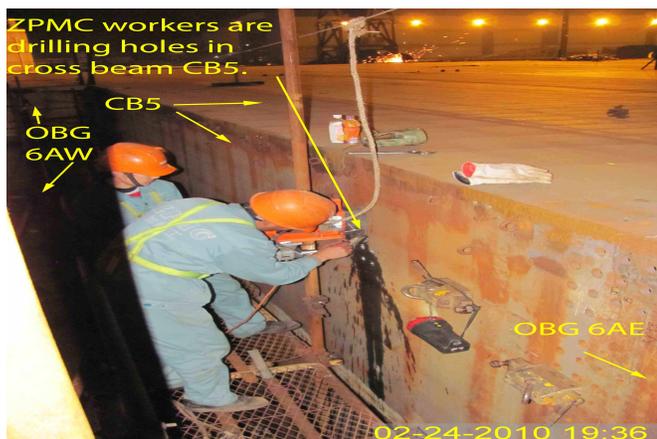
WELDING INSPECTION REPORT

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segment 6. See the photograph below for additional information.

ABF issued "Inspection Notification Sheet" number 02232010-1 item #1 informing QA that at 1830 hours ABF Inspectors will be performing ultrasonic (UT) inspections of repaired weld CA026-002,004,006 which joins the bottom plates of OBG segment 6AE deck plate to edge plate EP-W5 on the bikepath side. This QA Inspector observed weld CA026-002,004,006 has been marked by ABF ultrasonic inspectors as being UT accepted. This QA Inspector performed ultrasonic inspections at location 11755mm for detection of longitudinal and planar transverse indications utilizing scanning patterns A, B, C and D (AWS D1.5 Fig 6.7) and no UT rejections were observed. Items observed on this date appeared to generally comply with applicable contract documents.

ABF issued "Inspection Notification Sheet" number 02232010-2 item #1 informing QA that at 1800 hours ABF Inspectors will be performing ultrasonic (UT) inspections of repaired weld SEG027*-044,-048 which joins the bottom plates of OBG segment 6AW deck plate to edge plate EP-W5 on the cross beam side. This QA Inspector observed weld SEG027*-044,-048 has been marked by ABF ultrasonic inspectors as having an unacceptable longitudinal indication at Y=4205mm. This QA Inspector performed ultrasonic inspections at locations 3200 and 3210mm for detection of longitudinal and planar transverse indications utilizing scanning patterns A, B, C and D (AWS D1.5 Fig 6.7) and no UT rejections were observed, this QA Inspector confirmed the longitudinal indication at Y=4205mm and this weld will be repaired at a later time. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



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.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer