

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025174**Date Inspected:** 03-Jul-2011**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:** See Below**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**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:

Segment 13W Coating Inspections, ZPMC blast shop #4, Inspection time 21:15 hours

Notice of Inspection 7293 Item #1: ZPMC notified Caltrans QA Inspectors that segment 13W Internal west section floor and vertical floor beams between panel point PP119+1.5 meters and PP120.5 cross beam side have been grit blasted and are ready for visual inspections prior to application of paint. This QA Inspector arrived at segment 13W and was informed by ABF Inspectors that they have visually rejected these areas.

Segment 13W Coating Inspections, ZPMC blast shop #4, Inspection time 7-4-2011, 01:30 hours

Notice of Inspection 7297 Item #1: ZPMC notified Caltrans QA Inspectors that segment 13W Internal west section floor and vertical floor beams between panel point PP119+1.5 meters and PP120.5 cross beam side have been grit blasted and are ready for visual inspections prior to application of paint. This QA Inspector observed ZPMC and ABF Inspectors performing visual inspections of these areas and ABF informed this QA Inspector that these areas are accepted. This QA Inspector performed random visual inspections and items appear to comply with project specifications.

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# WELDING INSPECTION REPORT

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Catway Channels and Cable Support plate Coating Inspections, SPMP blast shop #C, Inspection time 19:30 hours

Notice of Inspection 7289: ZPMC notified Caltrans QA Inspectors that item #1: 22 each catway channels and item #2: 111 each SA6029 and SA6531 Cable support accessories have been grit blasted and are ready for visual inspections prior to application of paint. This QA Inspector observed ZPMC and ABF Inspectors performing visual inspections and profile measurements of these plates and they informed this QA Inspector the surface profile exceeds the maximum allowed and they will have SPMP workers reblast these items to reduce the profile. Approximately 30 minutes later ZPMC performed additional profile measurements and ZPMC informed this QA Inspector the surface profile is accepted.

Segment 13E Coating Inspections, Trial Assembly area

Notice of Inspection 7294 Item #1: ZPMC notified Caltrans QA Inspectors that segments 13AE, BE and CE exterior bottom plates have been painted and are ready for final dry film thickness measurements (DFT). This QA Inspector and two other QA Inspectors observed ZPMC and ABF Inspectors performing DFT measurements and observed the thickness paint on segment 13E bottom plates appears to exceed the maximum listed in the project specifications. ZPMC and ABF coating Inspectors agreed the paint thickness is excessive and they informed QA Inspectors they were rejecting this inspection.

Blast bay #2, OBG segments 14W

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 14W vertical plates located between PP125 and the anchor plate following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with two other QA Inspectors performed random visual inspections of these areas and observed multiple areas that require grinding to remove arc strikes, sharp edges, minor gouges and two areas that require weld repairs. Caltrans QA Inspectors' provided the locations of these weld repairs to dayshift QA personnel for adding this information to the 14W tracking database. See the photograph below for additional information.



## Summary of Conversations:

See Above.

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## WELDING INSPECTION REPORT

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### 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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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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