

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000432**Date Inspected:** 11-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gu Xin Zhai**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:** Mock Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe work being performed for the fabrication of the Mock Up at elevations 77 and 114.

Elevation 77:

The QA Inspector randomly observed ZPMC personnel rigging and setting up skin plates A and B in preparation to perform weld repairs found during ultrasonic inspection.

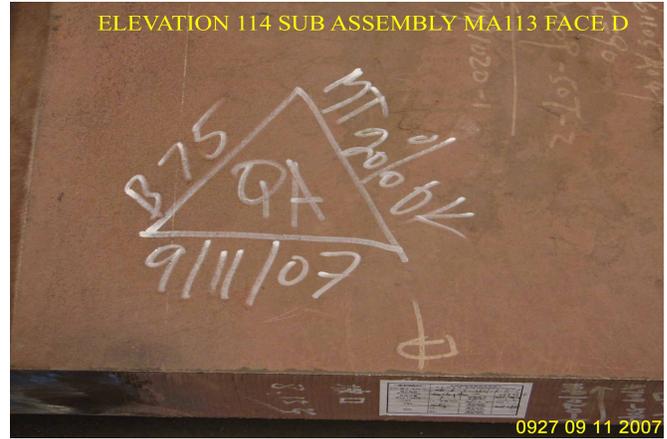
Elevation 114:

The QA Inspector observed ZPMC NDT Technician Zhou Dong Yun performing 100% Magnetic Particle Inspection (MT) inspection of the cover passes of weld joint (WJ) MUSC-MA108-1 and MUSC-MA108-2 of skin plate E and WJ's MUSC-MA113-1 and MUSC-MA113-2 of skin plate D. The QA Inspector also observed Mr. Zhou performing 100% MT of the areas where the lifting lugs had been removed. The QA Inspector performed 20% MT of the same areas on skin plates D and E of elevation 114. There appeared to be no indications and ZPMC CWI Gu Xin Zhai accepted the root passes for the above WJ's.

The QA Inspector observed the run off tabs being removed from skin plate B after welding longitudinal stiffeners piece marks MP1006 and MP1009 to sub assembly MA102 Face B.

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Summary of Conversations:

There were no relevant conversations.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer