

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001299**Date Inspected:** 05-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guogang**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 Mock Up**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 2- QA Inspector observed ZPMC Magnetic Particle Technician Cai Xin Xin performing magnetic particle testing on 77 Meter Mock up MAU-MA1 D/F Diaphragm Assembly. Testing was performed on Partial Joint Penetration (PJP) Welds at the root layers of welds #11 and #12. Both welds were found acceptable by Cai Xin Xin. QA Inspector performed 100% verification magnetic particle testing on these same welds upon completion by ZMPC. For details please see magnetic particle testing report TL-6028 dated January 05, 2007.

Bay 7- QA Inspector performed ultrasonic verification testing of Floor Beam Sub Assembly complete joint penetration welds. The Ultrasonic Testing (UT) was performed to verify that 10% of the welds meet the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60. The base metal lamination check was performed with a 1.0" dia. round 2.25 MHz transducer. The weld shear wave scan was performed with a 0.75" x 0.625" 2.25 MHz transducer on a 70 degree angle wedge from face A. Scanning patterns A, B, C, and E were utilized. For details please see the ultrasonic testing report TL-6027 dated January 05, 2007. QA Inspector found the following list of all the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents: FB014-02-002, FB014-02-020, FB014-04-002, FB014-04-020, FB005-02-002, FB005-02-020, FB005-04-002, FB005-04-020, FB005-05-002 and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FB005-05-020.



Summary of Conversations:

General communications took place between the QA and QC Inspector.

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: Quintana, Gabriel

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer