

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-001315**Date Inspected:** 18-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1615**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 930**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	77 & 114 Meter Mock-Up	

Summary of Items Observed:

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Ken Jobes, Paul Stovall, Dan Hernandez and Gabriel Quintana performing fabrication inspection out on the shop floor today.

Mr. Quintana performed 10% verification ultrasonic testing on floor beams in Bay 7. Floor beam welds tested were FB022-01-078, 079, 080, 081 & 101 and FB026-02-078, 079, 080, 081, 101 & 108. Weld joints FB022-01-081 & 101 and FB026-02-081 were marked for grinding. Unacceptable indications were observed requiring the welds to be ground smooth and flush. Mr. Hernandez observed welding in Bay 2 for the 77 Meter Mock-Up. Welds which the welding was witnessed were MUSA-SA95 weld joint 58 and MUSA-SA104 also weld joint 58. Mr. Jobes witness welding in the New Tower Shop for the 89 Meter Mock-Up on weld joints MUB-MA21 G/J-66 and MUB-MA21 A/J-6. Mr. Stovall worked on corrections and completion of reports.

77 Meter Mock-Up

This Quality Assurance Inspector proceeded to Bay 2 to perform ultrasonic and magnetic particle testing on the weld joint between skin plates A and E of this mock-up. Upon arriving in the shop the weld was visually gone over and found that while quality control had requested quality assurance inspection, quality control had not completed their testing and would not until tomorrow morning. All quality control personal from the non-destructive testing section of quality control was at a Zhenhua Port Machinery Company dinner party celebrating the New Year.

114 Meter Mock-Up

WELDING INSPECTION REPORT

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This Quality Assurance Inspector proceeded to Bay 2 to perform magnetic particle testing on three weld joints of this mock-up. Upon arriving in the shop the welds were visually gone over and found that while quality control had requested quality assurance inspection, quality control had not completed their testing and would not until tomorrow morning. All quality control personnel from the non-destructive testing section of quality control was at a Zhenhua Port Machinery Company dinner party celebrating the New Year

Summary of Conversations:

No conversations held today.

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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
