

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-001602**Date Inspected:** 18-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Cui Yi Ru**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:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 7 OBG:

The QA Inspector randomly observed ZPMC Non Destructive Testing Technicians E Shui Qin and Li Li Ming, utilizing the Ultrasonic Testing Method (UT), to examine WJ FB018-01-079 on Floor Beam Sub-Assembly FB018-01 for ZPMC Critical Weld Repair (CWR) 017. There were no apparent rejects observed.

The QA Inspector randomly observed ZPMC Non Destructive Testing Technicians E Shui Qin and Li Li Ming, utilizing the (UT), to examine WJ's 117 & 122 on Floor Beam Sub-Assemblies FB017-01, FB018-02 and FB021-01 after completion of heat treating Operations. There were no apparent rejects observed. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Non Destructive Testing Technicians E Shui Qin and Li Li Ming, utilizing the UT, to examine WJ's 043 and 045 on Floor Beam Sub-Assembly FB015-01 after a second time repair. There were additional rejects observed and recorded by the ZPMC UT Technicians.

The QA Inspector randomly observed ZPMC Non Destructive Testing Technicians E Shui Qin and Li Li Ming, utilizing the UT, to examine WJ's 043 and 045 on Floor Beam Sub-Assembly FB007-03 after a second time repair. There were additional rejects observed and recorded by the ZPMC UT Technicians. The attached photograph

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provides additional detail.

The QA Inspector randomly observed ZPMC Non Destructive Testing Technicians E Shui Qin and Li Li Ming, utilizing the UT, to examine WJ's 043 and 045 on Floor Beam Sub-Assembly FB008-02 after a third time repair. There were additional rejects observed and recorded by the ZPMC UT Technicians.



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
