

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-001871**Date Inspected:** 19-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	None	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:	SAS Tower	

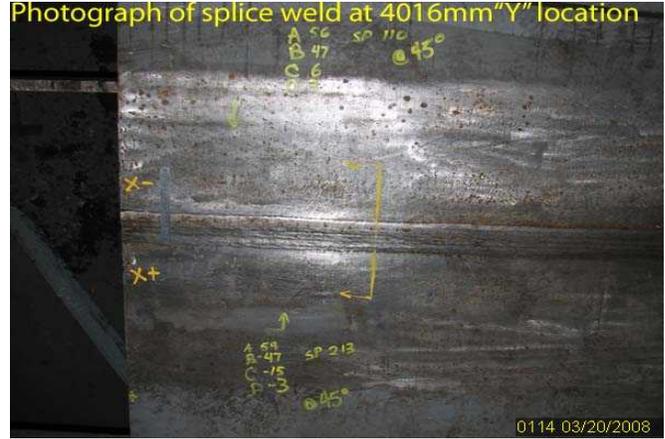
Summary of Items Observed:

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 4- QA Inspector performed ultrasonic verification testing of a Complete Joint Penetration (CJP) splice weld on the 43 Meter Diaphragm Sub Assembly SSD1-SA27-A/B-1A. Ultrasonic Testing (UT) was performed to verify that a minimum of 30% of the weld meets the requirements of the contract documents and AWS D1.5-2002. Total weld length is 4516mm. QA Inspector inspected 1500mm or approximately 30% of weld. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 45 degree angle wedge from Face "A" only. QA Inspector utilized Scanning patterns A, B, C, and E. QA Inspector performed a top and bottom quarter inspection of the weld per Table 6.2 of the AWS D1.5-2002. QA Inspector observed indications located at the toes of the weld which appear to be the result of the groove weld profile. Previous UT inspection was performed by Caltrans QC Inspector Erik Prue utilizing a 70 degree shear wave scan on the middle half and bottom quarter of the weld. For details please see the ultrasonic testing report TL-6027 dated March 19, 2008. QC Inspection was not complete at the time of QA Inspection. Indications noted above do not meet the contract documents at this stage of fabrication and will require further inspection.

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Summary of Conversations:

Caltrans QA Inspector Erik Prue informed QA Inspector that he completed a 70 degree UT inspection from Face "A". ZPMC QC Inspector Zhang Jiadi informed QA Inspector that the QC Inspection is not complete and that the assembly will be rotated on the following day for further UT inspection.

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: Hager, Craig

QA Reviewer
