

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-001924**Date Inspected:** 20-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**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:	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:	OBG	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay 7- QA Inspector witnessed ZPMC QC UT Inspector Mr. Ma Ji Long perform 100% Ultrasonic Inspection on floor beam sub assemblies Complete Joint Penetration (CJP) Butt splices on FB 003-021-101 & 006, FB 003-022-001 & 006, and FB 003-023-001 & 006. QA Inspector performed ultrasonic verification testing of 100% of QC UT acceptable floor Beam sub assembly welds. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. 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 70 degree angle wedge from face A. QA Inspector found QC UT inspection method and welds inspected to be in compliance with AWS D1.5 (02) Table 6.3 and the contract documents. For details please see the ultrasonic testing report TL-6027 dated March 20, 2008.

Bay 7: QA Inspector witnessed ZPMC QC MT Inspector Mr. Cai Xin Xin perform Magnetic Particle (MT) inspection of 10% for total weld length of stiffener to Side Plate fillet welds for Side Plate SP 001-001-001 thru 010. QA Inspector performed 10% minimum visual and magnetic particle inspections of portions of QC acceptable inspection of side plate to stiffener fillet welds. QA Inspector found QC MT inspection method and welds inspected to be in compliance with AWS D1.5 (02) and the contract documents. For details please see Magnetic particle testing report TL-6028 dated March 20, 2008.

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Summary of Conversations:

While observing QC UT inspection QA Inspector noticed there was no calibration sticker affixed to the QC UT machine being utilized for inspection. QA Inspector asked ZPMC QC Inspector Mr. Mai Ji Long if his UT machine was in current calibration in accordance with AWS D1.5 (02) paragraph 6.17.1 and 6.17.2. QC Inspector informed QA Inspector that his UT machine was in current calibration but they do not put a calibration sticker on the machine. QA Inspector asked QC Inspector to provide the calibration paperwork showing current calibration. QC Inspector informed QA Inspector that he would provide the calibration paperwork requested by lunch. QA Inspector received the calibration paperwork and reviewed it as acceptable.

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 Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
