

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-002076**Date Inspected:** 21-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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 performed minimum 10% Ultrasonic (UT) verification inspection of acceptable ZPMC QC UT inspection on floor beam sub assembly Complete Joint Penetration (CJP) Butt splices; FB 003-019-103, FB 003-020-103, FB 003-010-103, FB 014-060-043, and FB 014-050-042. 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 21, 2008.

Bay 7: QA Inspector witnessed ZPMC QC MT Inspectors Mr. Bo Tingrui and Mr. Cai Xin Xin perform 100% Magnetic Particle (MT) inspection of total weld lengths of stiffener to floor beam plate fillet welds for FB 021-001- various welds. QA Inspector performed 10% minimum visual and magnetic particle inspections of portions of QC acceptable inspection of stiffener to floor beam plate 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 21, 2008.

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Summary of Conversations:

QA Inspector observed during MT inspection by ZPMC QC MT Inspectors Mr. Cai Xin Xin and Mr. Bo Tingrui that MT particle application was too heavy. QA Inspector discussed with QC MT Inspectors that the application of the MT powder should be a light dusting. QA Inspector demonstrated the proper application of MT powder. QC MT Inspectors agreed and continued with MT inspection applying particle's properly.

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
