

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-001888**Date Inspected:** 06-Apr-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:	Chen Xie and Chen Chih-ming	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 deck and side panels	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG New Assembly Bay (CWI - Mr. Chen Chih-Ming)

QA observed welding being performed using the Submerged Arc Welding (SAW) process joining SP-061-001 to SP-049-001 to form segment #SEG-019A-015. ZPMC QC personnel was observed performing WPS parameter verifications and random in process weld inspection.

QA observed ZPMC Quality Control (QC) Magnetic particle Testing (MT) technician examining 10% of each of the fillet welds joining the T-stiffeners to the side and/or bottom plates on the following panels: SP-020-001, SP-016-001, BP-023-001 and BP-020-001. All MT'ed areas appeared to comply with the acceptance criteria of AWS D1.5 2002 and the contract documents. After QC completed their MT, QA performed 10% verification MT of the same welds and found the areas to be in compliance with the contract documents. Refer to QA's MT report (TL-6028) dated today for further details.

QA observed ZPMC QC Ultrasonic Testing (UT) technician identified as Z Shuigin examining 25% of the Complete Joint Penetration (CJP) web welds at the splice joints on the open rib T-stiffeners for the following side and bottom panels: SP-020-001, SP-016-001, BP-023-001 and BP-020-001. The scanned welds appeared to comply with the acceptance criteria of AWS D1.5 2002 and the contract documents. QA was informed by QA task leader that Caltrans UT technicians would perform UT verification on the above mentioned welds.

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OBG Bay 1 (CWI - Mr. Chen Xie)

QA performed Visual Testing (VT) on deck panel DP-459-001 welds W1 thru W5. All welds that were inspected appeared to exhibit some degree of lack of fusion, overlap, oversize and/or under fill. QA was unable to complete the visual inspection of this deck panel by shifts end. QA partially completed a Caltrans QA visual weld inspection report for the OBG deck panel mentioned above. The report is filed in the QA office.



Summary of Conversations:

No significant conversations were held today concerning this project.

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

Inspected By:	Hall, Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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