

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002521**Date Inspected:** 16-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hue Wei Qing**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 Panels**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.

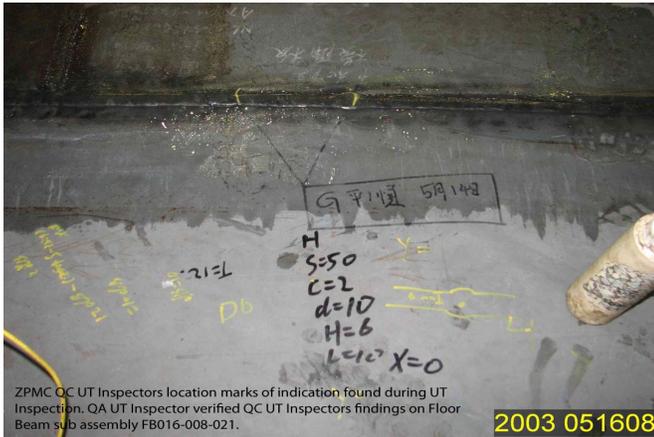
New OBG Bay 1: QA inspector performed ultrasonic testing (UT) verification before ZPMC Quality Control (QC) UT inspections on partial penetration joints of deck panels DP326-002 weld joint 2, DP409-001 welds 1 & 10, and DP353-001 weld joints 1 & 10. QA UT inspected 15% of the total weld length of weld joints listed above. QA Inspector found lack of penetration indications that result in depth of penetration less than the minimum of 9.6 mm required on weld joint for deck panels DP409-001 and DP353-001. Area inspected by QA UT Inspector for DP326-002 contained no areas of depth of penetration less than the required 9.6 mm. For details on UT inspections see modified TL-6027 UT Inspection reports dated 16 May, 2008.

Bay 7: QA Inspector observed ZPMC QC UT Inspectors Xue Hai Vong and Ma Ji Long performing Ultrasonic Testing (UT) on Floor Beams FB012-011-023, FB011-006-021, FB016-006-021, FB016-008-021, and FB016-013-021. During observation QA Inspector noticed high amplitude ultrasonic signals on QC UT inspector's machine. QC UT Inspectors continued the inspection without evaluating the high amplitude questionable indications. QA UT Inspector performed UT inspection and observed high amplitude ultrasonic signals with at various locations along the welds. QA UT Inspector rated indications as class "A" per AWS D1.5 table 6.3. Please see incident report generated this day for further details. 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; FB011-006-021 and FB016-013-021. For details please see the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ultrasonic testing report TL-6027 dated 16 May, 2008.



Summary of Conversations:

QA Inspector discussed with QC UT Inspectors and QC CWI about questionable UT indications found during QC UT inspection of floor beam sub assemblies listed above in items observed. Please see incident report generated this day for further details.

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:	Carreon,Albert	QA Reviewer
