

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-002675**Date Inspected:** 17-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**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:	Tower & OBG	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 1:

The QA Inspector performed a random 10% Magnetic Particle (MT) Inspection of Tower Skin Plate C WJ SSD1-SA179A/E-4B. There appeared to be no indications and the QA Inspector accepted WJ SSD1-179A/E-4B.

The QA Inspector attempted to perform a random 10% MT Inspection of Tower Skin Plate C WJ SSD1-SA179A/E-4A. The QA Inspector randomly observed that the weld was covered in rust and not ready for MT inspection. The weld was also facing downward resting on the weld table. The following photograph provides additional detail.

The QA Inspector performed a random 10% MT Inspection of Tower Skin Plate A Longitudinal Stiffener WJ SSD1-SA15A/F-32B. There appeared to be no indications and the QA Inspector accepted WJ SSD1-15A/F-32B.

The QA Inspector attempted to perform a random 10% MT Inspection of Tower Skin Plate A WJ SSD1-15A/F-32A. The QA Inspector randomly observed that the weld was covered in rust and not ready for MT inspection. The weld was also facing downward resting on the weld table. The following photograph provides additional detail.

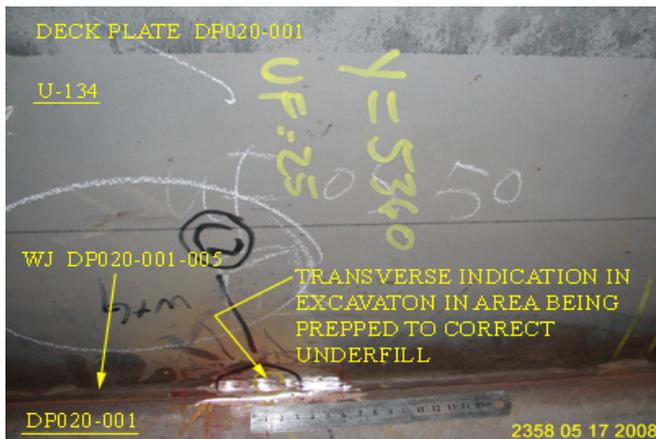
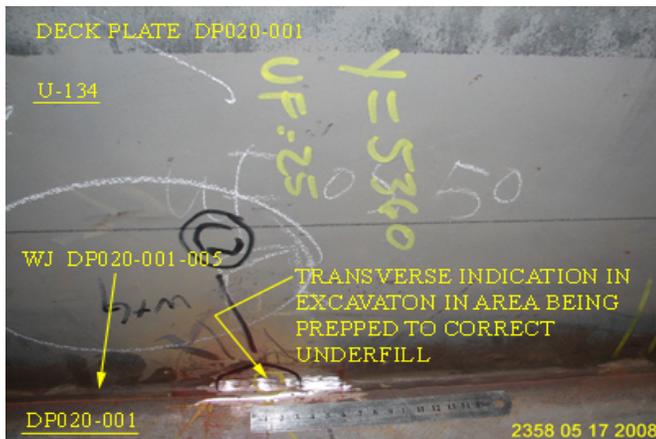
WELDING INSPECTION REPORT

(Continued Page 2 of 3)

New Tower Shop Bay 3:

The QA Inspector prepared to perform Visual Inspection (VT) of the welds attaching the U-Ribs to Deck Plate DP020-001 [Weld Joint (WJ) Numbers 001 through 006], after weld repairs. The tracking spreadsheet indicated that this Deck Plate was ready for QA VT Inspection after weld repairs. The QA Inspector randomly observed 1 excavation at location Y=5360, in WJ 005 and 2 more excavations in WJ 006. The QA Inspector randomly observed a transverse indication in the excavation in WJ 005. Deck Plate DP020-001 does not appear to be ready for VT after weld repairs. The attached photographs provide additional detail.

The QA Inspector prepared to perform VT of the welds attaching the U-Ribs to Deck Plate DP006-001 (WJ's 001 through 008), after weld repairs. The tracking spreadsheet indicated that this Deck Plate was ready for QA VT Inspection after weld repairs. The QA Inspector randomly observed approximately 3 meters of weld length in the center of WJ's 001 through 008, to be covered in Ultrasonic Testing couplant, dirt and rust. Deck Plate DP020-001 does not appear to be ready for VT after weld repairs. The attached photographs provide additional detail.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As noted in the above body of this report.

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:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
