

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-003247**Date Inspected:** 09-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Keng Chan**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**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 1

Skin Plate A South Tower Assembly

The Quality Assurance Inspector observed ZPMC in process tack welding longitudinal stiffeners to skin plate A South Tower Assembly.

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener plate P161B.

The Quality Assurance Inspector observed ZPMC in process of performing thermal cutting operations on skin plate B South Tower Assembly.

The Quality Assurance Inspector witnessed ZPMC Non-Destructive Technicians perform ultrasonic testing on complete joint penetration welds on skin plate D South Tower Assembly.

Bay 2

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener plate SA77 and P352.

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ESDI-SA216 H/K 7A

The Quality Assurance Inspector observed ZPMC welder 053316, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number SSDI-SA216 H/K 7A. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

Skin Plate A East Tower Assembly

The Quality Assurance Inspector observed ZPMC in process tack welding longitudinal stiffeners to skin plate A East Tower Assembly.

The Quality Assurance Inspector witnessed ZPMC Non-Destructive Technicians perform magnetic particle testing on complete joint penetration welds on skin plate C East Tower Assembly.



Summary of Conversations:

No relevant conversations on this date.

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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
