

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-003905**Date Inspected:** 19-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Wang Sei Fa**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 Assembly Comp.**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 1 – New Tower Shop**Magnetic Particle Testing**

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The deck weld designation numbers are as follows: NSD1-SA10J/K-1~4, 9A, 10A, 11A, and 18A.

Bay 7 – OBG Sub Assembly

This QA Inspector observed excavation performed by grinding, and in-process welding of Critical Weld Repair (CWR) 153. This QA Inspector observed the excavations to be an average depth of 6mm and in some cases to extend 15mm beyond the toe of the fillet weld into the base material. Photographic documentation has been filed with this report.

North Section Fabrication Area

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of deck plate splice filler passes. The personnel was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. The deck plate splice welds in process of welding are designated as: DP094-001, DP227-001, DP146-001, and DP536-001.

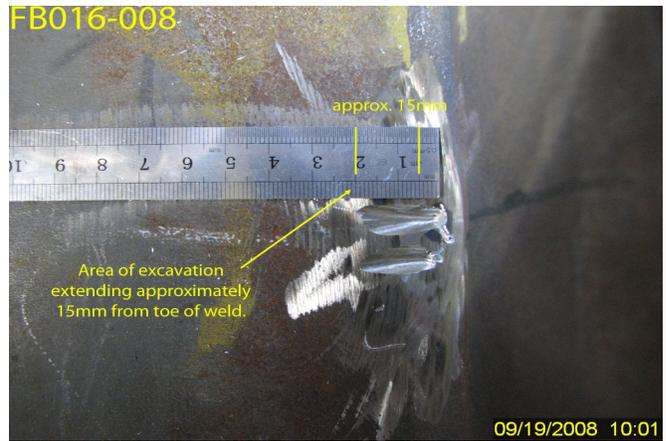
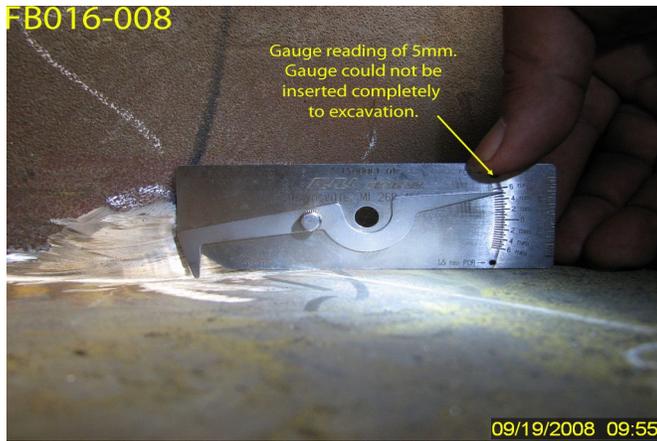
WELDING INSPECTION REPORT

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This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of closed rib deck plate splice filler passes. The personnel was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. The deck plate splice welds in process of welding are designated as: (DP553-001 to DP552-001), and (DP568-001 to DP567-001).

Tracking and Log Book

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.



Summary of Conversations:

No relevant conversations.

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 Ady Velasco, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
