

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-004154**Date Inspected:** 11-Sep-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:** Jeff Chen / Ck 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:** OBG / 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 orthotropic box girder and the tower.

Bay 1

The Quality Assurance Inspector was informed by American Bridge/Flour Representative Wang Zhen Hua, 46 indications on tack welds were discovered by magnetic particle testing and 10 out of the 46 indications were cracks on DP 234-001.

The Quality Assurance Inspector observed ZPMC in process of performing fit up operations on DP 389-001 to U-ribs.

Orthotropic Box Girders (OBG) Assembly Bay

The Quality Assurance Inspector accompanied by American Bridge Representative reviewed and randomly performed a visual observation on the welds for several sub assemblies for the purpose green tags. The Quality Assurance Inspector green tagged the following sub assemblies; SP-56A, SP-603B, SP-563B, SP523B, SP40B, SP55A, SP43A, EP18B and EP19B.

Heavy Lift Shop 1

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The Quality Assurance Inspector received a notification to witness ultrasonic weld testing from the ZPMC Quality Control Department. The time on the notification document number 01011 was 0830, location Heavy Shop number 1. The Quality Assurance Inspector arrived in Heavy Shop number 1 at approximately 0815. Upon the Quality Assurance Inspector arrival the Quality Assurance Inspector observed the ultrasonic testing on the welds SSDI-SA164 A/F-6 A/B and SSDI-SA164 A/F-7 A/B were completed by the ZPMC Ultrasonic Testing Personnel. The Quality Assurance Inspector asked American Bridge/ Flour Representative CK Chan why the testing was completed before the time on the notification. ABF Rep. CK Chan informed the Quality Assurance Inspector; the ZPMC Ultrasonic Technician informed him that they waited for the Quality Assurance Inspector before starting the testing. The Quality Assurance Inspector than again showed the ABF. Rep and the Ultrasonic Technician the time on the notification. ABF Rep. CK Chan informed the Quality Assurance Inspector, the ZPMC Ultrasonic Technician will scan the weld again. The Quality Assurance Inspector observed the ABF Rep. CK Chan walk away and than the ZPMC Ultrasonic Technicians laughed in the direction facing the Quality Assurance Inspector than gather their equipment and left the area without rescanning the weld.

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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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