

**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-004585**Date Inspected:** 08-Nov-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:** Hu Gui Hua**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**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.

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**Magnetic Particle Test**

The Quality Assurance Inspector performed 10% random magnetic particle testing verification the following side plate ; SP581A, SP726A, SP541A, and SP766A. See Caltrans report TL-6028 Magnetic Particle Test Report, dated Nov. 8, 2008 for additional information.

**SP726A**

The Quality Assurance Inspector discovered a crack indication overlooked by Quality Control while performing magnetic particle verification on weld # SP726A-001-030 located on the SP726A-001 side plate sub assembly. The Quality Assurance Inspector informed American Bridge/Fluor Quality Assurance Inspector Hu Gui Hua about the crack indication overlooked by ZPMC Quality Control Inspectors. Mr. Hua agreed with the Quality Assurance Inspector and informed ZPMC Quality Control Inspector Gui Yang Wei about the overlooked crack indication. The Quality Assurance Inspector observed ZPMC personnel have removed 1mm of filler metal by grinding in an effort to confirm if the indication discovered by the Quality Assurance Inspector is a surface indication. The Quality Assurance Inspector observed ZPMC Quality Control personnel perform magnetic particle testing on the ground area, revealing the crack indication is a sub surface indication. Mr. Hua informed the Quality Assurance

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Inspector a critical weld repair will be issued prior to welding the repair. See Caltrans Incident Report TL-0015, dated Nov. 8, 2008 for additional information.



## Summary of Conversations:

See above.

## 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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

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**Inspected By:** Lara, Raymond

Quality Assurance Inspector

**Reviewed By:** Wright, Mark

QA Reviewer