

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004784**Date Inspected:** 15-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

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:** Deck panels**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Part # Skin B.

1. The QA Inspector was requested to perform Ultrasonic Testing (UT) verification on a critical weld repaired made on the Complete Joint Penetration (CJP) weld identify as weld number SSD1-SA109-1A/B on inspection part number SKIN B for the tower section. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001425 for additional information. At the time of arrival at heavy shop 1 where the inspection part was located, the QA Inspector observed the skin plate was turn upside down and no access to perform the total UT verification was available. The QA Inspector notified ZPMC and ABF QC Inspection personnel of the accessibility to perform the verification and requested to flip the skin plate over. Later during the shift the QA Inspector observed that the skin plate was not flipped over and the verification was not performed on this weld. The QA Inspector notified Lead QA Inspector Kenneth Riley of the QA Inspector inability to perform the UT verification.

Part # Skin A1.

2. The QA Inspector was requested to perform Ultrasonic Testing (UT) verification on the Complete Joint

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Penetration (CJP) welds made on an inspection part identified as Skin A1 for the tower. (Note that multiple welds were made on this assembly). Please see the ZPMC Non Destructive Examination (NDE) notification document number 001425 for additional information. At the time of arrival at heavy shop 1 the QA Inspector observed the skin A1 plate was turn upside down and the access to perform the UT verification was not totally available. The QA Inspector notified ZPMC QC Inspection personnel of the accessibility to perform the verification. In addition to the access for the UT verification the QA Inspector observed that the QC Inspectors did not sign off the testing performed on these welds. The QA Inspector was notified by QC Inspector Kim Xiao the QC Inspector that performed the testing on these welds shall sign the acceptance or rejection of the tested welds and that the skim plate needed to be flipped over prior to the QA Inspector's verification. Later during the shift at approximately 2000 hours the QA Inspector was notified by the ABF and ZPMC QC Inspection personnel they did not know about the status of the testing and that tomorrow during the day shift more information will be available. The QA Inspector notified Lead QA Inspector Kenneth Riley of the QA Inspector inability to perform the UT verification.

Deck panel DP225-001 and DP252-001

3. The QA Inspector observed ZPMC QC Inspection personnel perform a final Visual (VT) and Magnetic Particle Testing (MT) on the completed Partial Joint Penetration (PJP) weld made between U-ribs and flat deck plates on the identified deck panel number DP225-001 and DP252-001. The ZPMC QC Inspector personnel did not report any welding related discontinuities and did not report any relevant indications during testing. The QC Inspection personnel notified QA Inspector the inspections were completed and the welds were reported to be acceptable.

a) At this location the QA Inspector performed a random VT and MT verifications on the completed PJP welds made between the U-ribs and flat plate of the identified deck panel number DP225-001 welds 001 through 010 for the OBG section and DP252-001 welds 001 through 010 for the OBG section. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001429 for additional information. The QA Inspector performed the VT and MT verification on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. (Please see note below). The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified QA Inspector Kenneth Riley of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Summary of Conversations:

As noted in the body of the report 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, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
