

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-004803**Date Inspected:** 26-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Le			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 skins		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG sub assembly bay 3

QA laid out 300mm areas (5% of weld length) to be Radiographically Tested (RT) on edge panel weld joints identified as EP072-001-001, EP084-001-001, EP076-001-035 and EP088-001-035 at the request of ZPMC QA Mr. Testino Wang.

Tower bay 2

QA received Non Destructive Testing (NDT) notification document no. 001490 from ZPMC QC and performed 10% verification Ultrasonic Testing (UT) on the following weld joints:

(Lift 1 west tower skin A)

WSD1-SA107D/J welds 1, 2, 7, 10, 15 and 19. All welds tested appeared to be compliant.

WSD1-SA107E/J welds 1, 2, 7, 8, 22 and 21. All welds tested appeared to be compliant.

WSD1-SA107G/J welds 1, 2, 7, 8, 22 and 21. All welds tested appeared to be compliant.

WSD1-SA107F/J welds 1, 2, 7, 8, 14 and 21. All welds tested appeared to be compliant.

WSD1-SA653A/F welds 7, 8, 9 and 10. All welds tested appeared to be compliant.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
