

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004821**Date Inspected:** 26-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Sub-Assembly Bay 1:

The QA Inspector randomly observed 2 Magnetic Drill Operators drilling bolt holes in U-Ribs U-90, U-91, U-92 and U-93 prior to forming.

OBG Sub-Assembly Bay 2:

The QA Inspector randomly observed 4 Magnetic Drill Operators drilling bolt holes in Skin Plate Stiffeners A709 HPS 485 piece mark A571 (E) and A709 Gr 345T2 p708 and p686.

OBG Sub-Assembly Bay 3:

The QA Inspector randomly observed ZPMC welders Sun Ti Yu ID Number 054459, Liu Zhi Hong ID 062447 and Li Shu Liang ID 048801, utilizing the Flux Cored Arc Welding (FCAW) Process in 2F Position on Gantry 2 with ZPMC WPS WPS-B-T-2132-3, to weld the I-Ribs to Side Plate SP468-001 WJ's 001/002, 005/006 and 009/010. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

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OBG Bay 4:

The QA Inspector randomly observed ZPMC NDT Technician Bo Tin Rui, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT examination on the cover pass of the fillet welds on Bottom Plate BP94A Yellow Tag 001929 (BP094-001) WJ's 007 through 018 and 043 through 054, BP148A Yellow Tag 001926 (BP148-001) WJ's 007 through 018 and 043 through 054 and Edge Plate EP65A Yellow Tag 001928 (EP065-001) Location 7AW-F9 WJ's 001 through 004. There appeared to be no indications and ZPMC QC accepted all the above listed welds.

The QA Inspector performed a 100% final Visual Testing (VT) and 10% MT verification on the cover pass of the fillet welds on Bottom Plates BP94A Yellow Tag 001929/Green Tag 001953 (BP094-001) Location 8CE-D6 WJ's 007 through 018 & 043 through 054, BP148A Yellow Tag 001926/Green Tag 001954 (BP148-001) Location 8CW-D6 WJ's 007 through 018 & 043 through 054 and Edge Plate EP65A Yellow Tag 001928/Green Tag 001953 (EP065-001) Location 7AW-F9 WJ's 001 through 004. There appeared to be no indications and the QA Inspector accepted all the above listed welds.



Summary of Conversations:

As noted in the above body of this report.

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, 15002199593, who represents the Office of Structural Materials for your project.

Inspected By: Franco, Charlie

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer