

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-004976**Date Inspected:** 03-Dec-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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	OBG and tower components	

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:

LIFT 2 WEST SKIN B, LIFT 2 SOUTH SKIN E.

1. The QA Inspector was requested to perform Ultrasonic Testing (UT) verification on the Complete Joint Penetration (CJP) welds made between component members on inspection parts listed on the ZPMC NDE notification of witness inspection document number 001537 item numbers 2, 3, 5 and 6. At the time of arrival at the heavy shop number 1, the QA Inspector could not locate the inspection parts and requested ZPMC QC Inspection personnel to provide support to find these inspection parts. ZPMC QC Inspector Ken notified the QA Inspector after investigation the inspection parts shown on the document could not be verify at this time at this location due to the fact that the NDE personnel have not completed the inspections on these welds as of this time. The QA Inspector did not perform the UT verification at this location and notified Task Leader Albert Carreon of issue mentioned above.

WSD1- SA80A/E, WSD1- SA294A/G.

2. The QA Inspector performed a random Visual (VT) and Ultrasonic Testing (UT) verifications on the Complete Joint Penetration (CJP) butt splice welds identify as weld number: WSD1- SA80A/E- 41A/B for tower section

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

LIFT 1 WEST SKIN D. WSD1- SA294A/G- 12A/B for tower section LIFT 1 WEST SKIN C. Please refer to ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001537 item numbers 1 and 4 for additional information. The QA Inspector performed the UT verification after ZPMC QC Inspectors reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on any of the verified welds. The QA Inspector notified ZPMC QC Inspection personnel and Task Leader Albert Carreon of the QA Inspector verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

OBG floor beam plates.

3. The QA Inspector performed a random VT and UT verifications on the CJP welds made between component members on inspection parts identify as: FB027-005, FB014-027, FB013-023, FB005-024, FB013-018, FB014-019, FB005-020, FB013-022, FB013-023 and FB004-019 (please note that welding repairs had been made on these welds). Please refer to ZPMC Non Destructive Examination (NDE) notification document number 001537 item numbers 7 to 17 for weld numbers and additional information. The QA Inspector performed the UT verification on these welds after ZPMC QC Inspectors had performed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did no observe any rejectable welding discontinuities on the verified welds. The QA Inspector notified ZPMC QC Inspection personnel and Task Leader Albert Carreon of the QA Inspector verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) 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
