

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-006835**Date Inspected:** 16-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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 crossbeams**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 cross beam CB4

This QA commenced documentation of segment green tag Non Destructive Testing (NDT) performed by Caltrans QA on the above mentioned crossbeam. Documentation accounted for all of the Ultrasonic Testing (UT) and Magnetic particle Testing (MT) performed on each segment weld. The document has been stored on the Caltrans (CT) server under team OBG // segment green tags // CB4.

This QA performed random Visual Testing (VT) on this crossbeam after the contractor and American Bridge Fluor (ABF) inspectors inspected and accepted all of the welds and material. This QA identified several weld and material discontinuities that did not appear to comply with the contract documents. The contractors QC verified these areas and instructed ZPMC personnel to repair the areas by grinding. After the repairs were completed this QA re-inspected the repaired areas and found all appeared to comply with the contract documents.

OBG cross beam CB5

No significant work was observed on the above mentioned crossbeam during the time QA was present.

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OBG cross beam CB6

No significant work was observed on the above mentioned crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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| Inspected By: | Hall,Steven | Quality Assurance Inspector |
| Reviewed By: | Prue,Erik | QA Reviewer |
