

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-009709**Date Inspected:** 03-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 Trail Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

QA Inspector was involved in preparing Ultrasonic Testing procedure for Transverse Segment Assembly Splices. This procedure is for the detection of Suspected Transverse Planar Discontinuities with Significant Flaw Height Dimension.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG 2AW welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed a rejectable indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified was identified as listed below:

OBG Assembly Yard

1. SSD11-PP15-002

This QA Inspector observed a Class A discontinuity present in the weldment accepted by ZPMC QC UT personal. This QA Inspector issued an incident report on the above noted UT rejection.

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This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBW 2A-005 and OBW 2A-006 utilizing scanning pattern D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated October 3rd, 2009 for further information on inspections.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

Summary of Conversations:

No relevant conversations.

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: | Dsouza,Christopher | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
