

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009754**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:** Xu Yumin and Li Jia**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:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz 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 Assembly Yard

2AE & 2BE

This QA Inspector performed Magnetic Particle (MT) inspection of weld joint OBE2A-004 transverse indication excavations performed by ZPMC. MT inspection was performed at each layer removed by air arc and hand held excavation method. Y locations, depth and number of transverse indication are as followed:

1. Y location 5370 to 5500mm, start depth was approximately 8.53mm. First depth from starting depth was approximately 9.88mm, 2 transverse indications were present. Second depth was approximately 11.09mm, 1 transverse indication was present. Third depth was approximately 11.75mm, no transverse indication was present. Fourth depth was approximately 12.04mm, 3 transverse indications were present. Fifth and final depth was approximately 13.80mm, 9 transverse indications were present. ZPMC worker stopped at last recorded depth.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

2. Y location 7650 to 7740mm, start depth was approximately 8.24mm. First depth from starting depth was approximately 10.93mm, 7 transverse indications were present. Second depth and final depth was approximately 13.51mm, 7 transverse indications was present. ZPMC worker stopped at last recorded depth.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Grit blasting of various internal areas in segment 1AE. (Panel point 10~10.5)
2. UT reject excavations in OBW1A-004 side plate weld joint located on crossbeam side of segment. Y locations are as followed: 2790, 2900 and 3330mm.
3. UT reject excavations in OBW1-001 deck plate weld joint located on counter weight side of segment. Y location is as followed: 23,120mm.
4. Grit blasting of various internal areas in segment 2E.

Note:

Due to China National Holiday, work was limited in the OBG Trail Assembly Yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
