

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-010508**Date Inspected:** 28-Nov-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:****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:** Trial 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:

ABF Inspection Request No. 11282009-1

This QA Inspector witnessed ABF Inspectors performing UT of

SEG004A - 004 (1E, WP - E4)

OBW3A - 003 (3AW - 3BW BP)

OBE1A-008 (1AE - 1BE BP)

OBE1-001 (1AAE - 1AE DP)

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

UT performed on the following repair areas utilizing scanning pattern A, B, C and D

SEG004A - 004 (1E, WP - E4)

OBE1A-008 (1AE - 1BE BP)

OBE1-001 (1AAE - 1AE DP)

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See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 28th, 2009 for further information on inspections.

ABF Inspection Request No. 11262009-3

This QA Inspector witnessed ABF Inspectors performing UT of CA102-002, 004, 006 AND CA004-002, 004 AND 006 (3E DP-SP BP side)

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

UT performed on repair areas of UT of CA102 - 002, 004, 006 and CA004 - 002, 004, 006 utilizing scanning pattern A, B, C and D (Fig 6.7)

This QA Inspector witnessed ABF Inspectors performing UT of SEG014A-043, 047 and CA103-002, 004, 006 (3E DP-SP CB side)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 28th, 2009 for further information on inspections.

ABF Inspection Request No. 11252009-5

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

UT performed on repair areas of UT of CA008 - 002, 004, 006 and CA012 - 002, 004, 006 (4E, WP E2, DP-EP, BK Side)utilizing scanning pattern A, B, C and D (Fig 6.7)

2AW – 2 BW

This QA Inspector witnessed ABF Inspectors performing UT of OBW2-002, 003 (2AW – 2BW SP BP side)

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

UT performed on repair areas of UT of OBW2-002, 003utilizing scanning pattern A, B, C and D (Fig 6.7)

4AE – 4 BE

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

UT performed on repair areas of UT of SEG20* – 035, 037/ CA10-002, 004, 006 utilizing scanning pattern A, B,

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C and D (Fig 6.7)

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

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.

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