

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-010720**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** You Qi Guo, Tu Jun**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) Shrikant Utekar 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:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after American Bridge Fluor (ABF) Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on bike path side edge panel splice weld between OBG segment 6AE and 6BE (OBE6-005) utilizing scanning pattern A, B, C and D (Fig 6.7).

No relevant indications were found.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after American Bridge Fluor (ABF) Ultrasonic Testing (UT) department for detection of planar transverse indication.

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Ultrasonic Testing (UT) performed on side panel(cross beam side) splice weld between OBG segment 6AE and 6BE (OBE6B-002) and (OBE 6B-003 in between Y location 4030 to 8245mm) utilizing scanning pattern A, B, C and D (Fig 6.7).

No relevant indications were found.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after American Bridge Fluor (ABF) Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on cross beam side edge panel splice weld between OBG segment 6AE and 6BE (OBE6-001) utilizing scanning pattern A, B, C and D (Fig 6.7). During the Ultrasonic Testing (UT) this Quality Assurance (QA) Inspector found one transverse linear indication that had not identified by ABF.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated 12/11/2009 for further information on inspections.

Unless otherwise noted, all work observed on this dated appeared to generally comply with 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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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