

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-015012
Date Inspected: 16-Jun-2010

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:	N/A	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 11BW

ABF Request No: 06162010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Counter weight side) of OBG segment 11BW. Inspection was carried out on repair areas. The weld designations are as follows.

CA083-004 (OBG 11BW, D.P to E.P – Counter weight side)

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG SEGMENT 8BW-8AW

ABF Request No: 06152010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the side panel splice weld (Counter weight side) between OBG segment 8AW and 8BW. Inspection was carried out on repair areas. The weld designations are as follows.

OBW8B-002 (OBG 8BW-8AW, S.P-Counter weight side)

OBG SEGMENT 8CW

ABF Report No: UT-8W-046

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and bottom panel (counter weight side) of OBG segment 8CW. The weld designations are as follows.

SEG047B-046 (OBG 8CW, S.P to B.P, Counter weight side)

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 11AW

ABF Request No: 06162010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and edge panel of OBG segment 11AW (Counter weight side). Inspection was carried out on repair areas. Weld identification number were.

CA083-004 (OBG 11BW, D.P to E.P – Counter weight side)

No relevant indications were observed.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8AW-8BW

ABF Request No: 06152010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the side panel splice weld (Counter weight side) between OBG segment 8AW and 8BW. Inspection was carried out on repair areas. Weld identification number were.

OBW8B-002 (OBG 8BW-8AW, S.P-Counter weight side)

No relevant indications were observed.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.

Summary of Conversations:

Only general conversation was held between QA and QC

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
