

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000809**Date Inspected:** 09-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**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:	89 & 114 Meter Mock-Ups	

Summary of Items Observed:

89 Meter Mock-Up

This QA Inspector witnessed the ultrasonic testing (UT) of the 89 Meter Mock-Up MUSB-MA22 Skin Plate 'D' complete joint penetration (CJP) weld joint 1A/B. Testing was performed by ZPMC UT Technicians Li Li Ming, Xue Hai Yong and E Shui Qin using zero, 60 and 70 degree transducers on the 60 millimeter (mm) thick weld section and 45 and 70 degree transducers on the 90 mm section which were in the as welded condition. Testing was carried out from both the A and B sides. The weld was found to be unacceptable by both Mr. Li Li Ming.

114 Meter Mock-Up

The QA Inspector performed 10% verification UT on the 114 Meter Mock-Up Skin 'B', MUSC-MA102 and Skin 'C', MUSC-MA111 complete joint penetration (CJP) t-joint welds. These were all longitudinal stiffeners to base plate welds and were carried out from side A and side B. For details please see ultrasonic testing report 6027 dated November 9, 2007.

Summary of Conversations:

No conversations held today.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer