

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-000891**Date Inspected:** 21-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Lujian Ping**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:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Magnetic Particle testing (MT) and Marco Etch Sample location and numbering for Orthotropic Box Girder, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

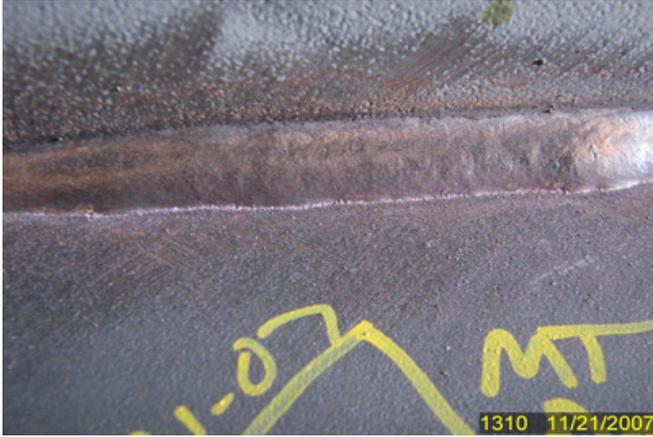
Caltrans QA Inspector Viars observed areas of the Closed Rib Weld Trial # 2 that had been thermally cut on the closed rib and deck plate juncture. ZPMC QC Shen Xue Jun stated that the areas were removed on the previous swing shift for Macro Etch testing for Loss of Penetration by ZPMC Personnel. Caltrans QA measured the locations of sample removal as well as requesting information as from which location the number samples came from. The information of sample numbering was provided by Mr. Shen Xue Jun. Sample removal area on U-rib # U73 was located from 1116 mm to 1795 mm and samples # 1 and # 2 were reported to be from this area. Sample removal area on U-rib # 02 was located from 3506 mm to 3897 mm and sample # 1 was reported to be from this area. Please see the attached photo of areas removed by thermal cutting from OBG closed rib weld trail # 2.

Magnetic Particle testing was reported to be performed by ZPMC QC Mr. Zhou Dongyun on OBG bottom plate 012 BB welds BP-012-01-013 to BP-012-024 T stiffener cover pass. Caltrans QA Inspector Viars observed areas that appeared to be overlap on the cover pass where tack welding had been previously performed. Caltrans QA Inspector Viars performed Magnetic Particle Testing on approximately 300 mm of both welds BP-012-01-014 and BP-012-01-017. A linear indication of 70 mm was noted on on weld # BP-012-01-014 and a linear indication measuring 75 mm was found on weld BP-012-01-017. The indication were removed by ZPMC and retested. The excavation areas were found acceptable by ZPMC as well as Caltrans QA Inspector Viars. Please see the attached photo below of MT indication located on BP-012-01-014.

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The Caltrans QA Inspector performed Magnetic Particle examinations of the OBG bottom plate T stiffener welds. Caltrans QA Inspector observed that the testing appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.



Summary of Conversations:

As identified within the contents of this report.

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 for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
