

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-001016**Date Inspected:** 18-Dec-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:** Shanghai, China**CWI Name:** Lu Jian 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:** Tower Mock-up and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item Description	WBS	Dwg No.	Status
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1	Ultrasonic Testing OBG		
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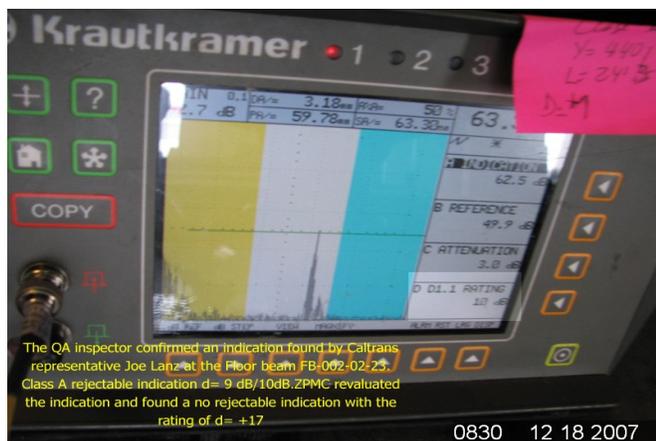
The QA inspector performed ultrasonic testing verifications to the weld joint at the floor beam section FB-002-02-023.

The QA inspector was verifying a UT rejectable indication found by Caltrans representative Joe Lanz. The QA inspector concurred with Mr. Joe Lanz location and rating; Y= 440 mm, X= 0, L= 24 mm, C = 2.91 and rating d = +9.

The QA Inspector informed ZPMC representatives Li Li Ming and Fu Yu Hong that the QA inspectors found a rejectable indication at the location and with the rating mentioned above. The QA inspector brought to the attention of ABF representatives David LeRue and Kevin Dye that a rejectable indication was found at the location mentioned above by Caltrans representative Mr. Joe Lanz. Later, ABF representatives relayed that Mr. Warren Beulher was going to verify the indication. ZPMC verified the indication and found +16 dB rating in lieu of +9 dB rating found by the QA inspectors. ZPMC used 3 different scopes and 3 different chinese brand transducers but with oil in lieu of water base couplant (used by the QA inspectors and ABF representative). Mr. Warren Buelher verified the indication and found a rejectable indication + 8 dB rating which it concurred with Caltrans representatives. The QA inspector recommended to Mr. Warren Buelher that ABF should trouble shoot ZPMC's UT verifications and results against ABF and Caltrans by checking the rejectable indication with the same couplant and IIW calibration block; and if it is necessary use the same transducer.

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Summary of Conversations:

As noted above.

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: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer