

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: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001370**Date Inspected:** 04-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**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:****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 assemblies**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production fabrication of the SAS Superstructure.

Bay 7: The QA inspector was directed to survey the partially completed Floor Beam diaphragm assemblies that are located in Bay 7. The QA inspector was informed that ZPMC Quality Control (QC) personnel have been inspecting and identifying apparent transverse cracks in fillet welds on the flanges, stiffeners and intermediate stiffeners of the assemblies. The QA inspector was informed that ZPMC workers are also in the process of removing the transverse cracks and other indications that have been identified by QC inspection. The QA inspector Paul Stovall assisted the QA inspector in making this survey.

The survey was conducted on these partially completed assemblies, types FB001, FB002, FB007, FB008, FB015 & FB016. During the survey, the QA inspector noted that several of the assemblies have visible markings from ZPMC QC personnel that indicate magnetic particle testing (MT) Rejected, however, no indications were visible of what portions of welds were rejected. The QA inspector also observed areas where possible weld repairs have been made to the fillet welds. The locations of the transverse cracks, as identified by QC, were mapped onto representative drawings of the floor beam diaphragms. Also during the survey, the QA inspector noted that assemblies FB007-03, FB008-01, FB008-04, FB015-01 & FB016-01 have writing visible of MT Accepted, all dated 1-22-2008. There was no verification of the welds' conditions on these assemblies at this time.

Summary of Conversations:

The QA inspector Scott Croff had conversations with the QA inspector Paul Stovall regarding the above mentioned survey and the observations of the conditions of the welds. There were no notable conversations with

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

any ZPMC personnel regarding the above mentioned observations. The QA inspector Scott Croff verified the collected information and then generated a summary report to be included in the daily shift log. There were no other notable conversations during this shift.

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:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
