

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-001432**Date Inspected:** 19-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guogang**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 Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 7- QA Inspector performed ultrasonic verification testing of Floor Beam Sub Assembly complete joint penetration welds on FB22-01 and FB17-02. The Ultrasonic Testing (UT) was performed to verify that 10% of the welds meet the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan was using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. QA Inspector utilized Scanning patterns A, B, C, and E. QA Inspector observed indications at weld FB022-01-079, FB022-01-081, FB022-01-101, FB022-01-108, FB017-02-079 and FB017-02-101 all of which will require further testing to determine if weld geometry is the cause of the indications. QA Inspector found all other welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

For details please see the ultrasonic testing report TL-6027 dated January 19, 2008.

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Summary of Conversations:

General communications took place between the QA and QC Inspector.

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:	Quintana, Gabriel	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
