

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-001611**Date Inspected:** 29-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ye Yongjun**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 Meter Mockup/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 joint FB008-02-043. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets 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 and B. QA Inspector utilized Scanning patterns A, B, C, and E. For details please see the ultrasonic testing report TL-6027 dated January 29, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

Tower Shop- QA Inspector observed QC Inspectors Li Li Ming and Xue Hairong performing ultrasonic inspection on the 89 Meter Mockup at skin "A" to "B" weld map MUB-MA21-D/J-2A and skin "B" to "C" weld map MUB-MA21-D/J-3A. QA Inspector observed that no indications were located during the QC Ultrasonic Testing (UT). QA Inspector observed that the UT inspections were performed using a 0 degree, 60 degree and 70 degree angle. QA Inspector observed QC Inspector Li Li Ming perform calibration of the UT equipment using a 70 degree angle. QA Inspector observed that no stencil or markings were placed on or near the inspection locations

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to indicate the test results. QC Inspector informed QA Inspector that QC Inspection will not be completed until access to all locations is provided. At this stage of fabrication, it appears that QC Inspectors are performing their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project.



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