

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-001846**Date Inspected:** 20-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:

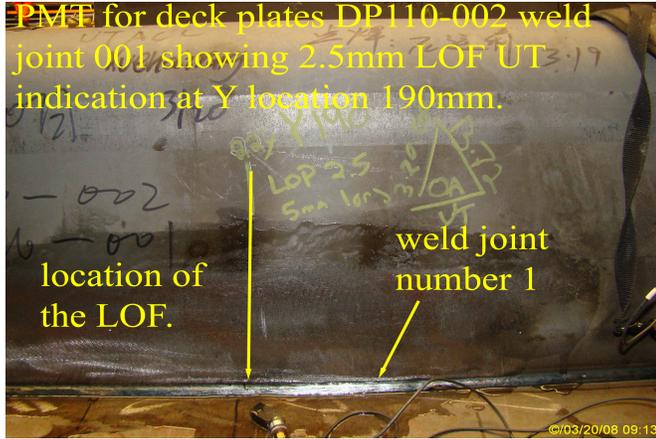
This Quality Assurance Inspector (QAI) completed depth of penetration ultrasonic testing of welds 001-006 for PMT-1 DP110-002 & DP326-001. All welds appeared to meet the requirements of the code and special provisions. For details see the ultrasonic report TL-6027 modified dated March 20, 2008.

This QAI performed depth of penetration ultrasonic testing on sample plate 7 in the American Bridge/Fluor (ABF) offices. There are a number of plates and are for the purpose of checking the ultrasonic measured lack of penetration against destructive testing measurements. After the taking of approximately 7 areas it was noted that this QAI reading all showed larger LOP than the ZPMC measurements. It was also realized that the ZPMC measurements were taken with correction factors instead of straight readings based on the calibration from the EDM notched T-joint blocks. All further testing was halted for discussions to take place between ABF, ZPMC and Caltrans on how to proceed.

This QAI read Macros for three separate production monitoring tests (PMT) today. The first one read was PMT DP074 which had 15 specimens total; one failure for lack of penetration (LOP) was recorded. The second was PMT DP243/DP405 which had 15 specimens listed with only 14 being received and had 2 specimen with failures for LOP. The third and last was for PMT DP382/DP077 which had 15 specimens with no failures, but one specimen had a crescent shaped area of LOP which was tagged for photographing by QAI Dave Smith on the second shift.

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Summary of Conversations:

Spoke with Art Peterson of ABF and both Fu Yu Hong and Sun Wei of ZPMC concerning today's macros for to days PMT DP110/DP326. At 1600 only 4 of the 15 samples were etched. Both Art Peterson and Sun Wei stated that these would not be read by them until 0800 tomorrow March 21, 2008.

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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer