

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-001872**Date Inspected:** 23-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 600**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:

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 3- QA Inspector observed that no welding was in progress in Bay 3.

Bay 4- QA Inspector observed that no welding was in progress in Bay 4.

Bay 1- QA Inspector performed an Ultrasonic Test (UT) verification of U-Rib Complete Joint Penetration welds (CJP) splice welds. Each of the following U-Rib splice welds were UT inspected for a length of 300mm on each leg of the rib: DP002-002-010 thru DP002-002-013 and DP054-001-012 thru DP054-001-016. QA Inspector performed a random UT inspection on 10% of the full length of CJP splice weld on Deck Plate DP002-002. CJP splice weld number DP002-002-009 joins plates PL2D to PL2C on the Deck Panel. QA Inspector also performed a random UT inspection on 10% of the full length of CJP splice weld on Deck Plate DP054-001. CJP splice weld number DP054-001-011 joins plates PL113B to PL113D on the Deck Panel. 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 scans 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. For details please see the ultrasonic testing report TL-6027 dated March 23, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

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Summary of Conversations:

No conversations 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:	Hager, Craig	QA Reviewer
