

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-001875**Date Inspected:** 14-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**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 Deck Panels	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

QA Inspector met with QA Inspector Mr. Alfredo Acuna and assisted him with Ultrasonic testing (UT) inspection on partial penetration (PJP) welds for deck panels. QA Inspector performed UT verification with Mr Alfredo Acuna after ZPMC Quality Control (QC) UT inspections on partial penetration joints of the deck panel DP-060-001 to the U-Rib weld joints. ZPMC QC UT inspected 15% of total weld length of each weld joint. QC UT Inspectors found lack of penetration indications that results in depth of penetration less than the minimum of 9.6 mm required on weld joints. QA UT Inspector inspected 100% of required 15% QC UT inspection per weld joint. QA UT Inspector verified ZPMC QC UT findings. QA Inspector took UT thickness readings on DP 062-001 and DP 063-001 adjacent to UT indications found by QA UT Inspector Mr. Alfredo Acuna. For details on UT inspections see Mr. Alfredo Acuna's modified TL-6027 UT Inspection report generated on this date.

Summary of Conversations:

Conversations noted in items observed above.

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 Partick Lowery, (858) 344-2712, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Prue,Erik	Quality Assurance Inspector
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Reviewed By:	Hager,Craig	QA Reviewer
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