

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-001877**Date Inspected:** 26-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 Deck Panels	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, 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 UT inspector performed 100 % ultrasonic verification testing (UT) of acceptable QC UT 100% inspection of partial penetration joints on production monitoring tests (PMT) welded this day. PMT 1 for deck panels DP-434-001/DP-191-001 welds 1 thru 6 for gantry #1. Please see modified UT report TL-6027 generated on this date.

QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspections on partial penetration joints of the deck panels DP-029-001 and DP-028-001 to the U-Rib weld joints # 1 thru 6. QC UT inspected 15% of the total weld length of each weld joint. ZPMC 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 for both deck panels. QA UT Inspector inspected 100% of required 15% QC UT inspection per weld joint. QA UT Inspector verified ZPMC QC UT findings. For details on UT inspections see modified TL-6027 UT Inspection report generated on this date

Summary of Conversations:

QA Inspector reminded ZPMC QC UT Inspector Mr. Li Li Ming to stencil on deck panels the following information when UT inspection is complete; inspector, date inspected, and acceptable or rejectable. Mr. Li Li Ming agreed and will ensure the information is stenciled on deck panels.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

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