

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-001878**Date Inspected:** 27-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 inspector performed ultrasonic testing (UT) inspection on partial penetration joints of the deck panels DP-245-001 to the U-Rib weld joints # 1 thru 10. QA UT Inspection normally occurs after ZPMC QC UT inspection but on this deck panel QA UT inspector Mr. Erik Prue was directed by task leader Mr. Robert Cuellar to perform UT inspection prior to QC inspection. QA UT inspected 15% of the total weld length of each weld joint.

QA UT Inspector found lack of penetration indications that results in depth of penetration less than the minimum of 9.6 mm required on weld joints for deck panel. For details on UT inspections see modified TL-6027 UT Inspection report 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 panel DP-067-001 to the U-Rib weld joints #1 thru #10. QC UT inspected 15% of the total weld length of each weld joint. QA UT Inspection is 50% complete and will be completed for deck panel tomorrow. A modified TL-6027 UT report will be generated at the completion of the testing.

Summary of Conversations:

No significant conversations this day.

Comments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
Reviewed By:	Hager,Craig	QA Reviewer
