

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-002058**Date Inspected:** 28-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1545**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhu Zhonghai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower Skin Plates**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

New Tower Shop-Bay 1 & Bay 2

The QA Inspector performed ultrasonic testing (UT) verification in accordance with AWS D1.5-2002, table 6.3 for approximately 10% of the weld length on the following tower skin plate weld joint designations, SSD1-SA173-J/K-7A-7B, SSD1-SA173-J/K-8A-8B, SSD1-SA173-K/K-14B and ESD1-SA273A/F-1A-1B. The QA Inspector used a 45 degree shear transducer/plastic wedge combination for the top ¼ of the weld joint and a 70 degree shear wave transducer/plastic wedge combination for the middle half and bottom ¼ of the weld joint. The UT was performed after ZPMC UT personnel previously accepted these weld joints. No relevant indications were observed upon completion of testing. The QA Inspector generated a TL-6027 UT report for the examination. Please refer to this report for further details.

Summary of Conversations:

No relevant conversations this date.

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.

WELDING INSPECTION REPORT

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Inspected By:	Leach,Ed	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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