

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002210**Date Inspected:** 12-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**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:** Orthotropic Box Girder**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.

Bay7

The QA Inspector along with QA Inspector Kenneth Riley were requested to perform ultrasonic testing for a total of sixteen (16ea) floor beam triangular shaped diaphragm plates. Upon arriving to the shop, it was discovered by QA Inspector Kenneth Riley that ZPMC personnel had previously performed and accepted UT prior to performing visual inspections. The markings on the plates indicated that visual inspections had not been completed. The QA Inspectors' were informed by ZPMC lead QC personnel Wang Lu that ZPMC has completed visual inspections on these plates and that he will notify the CWI to sign off the inspection on the plates. Mr. Riley informed QA Inspector Edward Leach that an incident report was previously generated for this same issue. Later in the shift, ZPMC QC Inspector Li Zhi Jiang arrived at bay 7 to sign his name to the material documenting that visual inspections were completed on these sixteen pieces of plate.

Later in the shift QA Inspectors' Kenneth Riley and Edward Leach completed 10% UT for the weld splices of sixteen pieces of floor beam diaphragm plates. This QA Inspector completed 10% for pcmk FB009-009-026, FB016-009-026, FB016-010-026 and FB016-011-026. The QA Inspector performed a straight beam scan for lamination prior to performing shear wave. Approximately 200mm of weld length were scanned on each weld using a 70 degree shear wave transducer/plastic wedge combination. The QA Inspector also performed UT for the complete joint penetration (CJP) weld joint on floor beam diaphragm designation FB026-01-021. A total of 80mm

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

(full length) of weld length were scanned using the same UT sequence and shear wave angle as above. No relevant indications were noted upon completion of testing and a TL-6027 UT report was generated on this date for these items.

Summary of Conversations:

As noted above in report.

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:	Leach,Ed	Quality Assurance Inspector
----------------------	----------	-----------------------------

Reviewed By:	Hager,Craig	QA Reviewer
---------------------	-------------	-------------