

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-002620**Date Inspected:** 23-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yuhong**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:**

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.

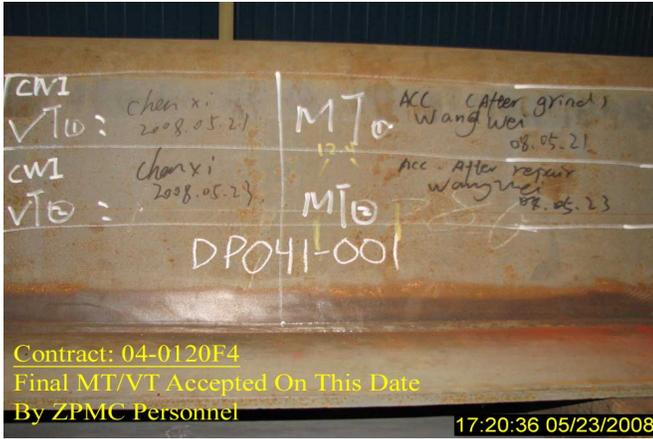
New Tower Shop-Bay 3

The QA Inspector observed that ZPMC personnel completed final magnetic particle testing (MT) and visual testing (VT) after repairs were complete for deck panel designations DP040-001 and DP041-001. Both deck panels were signed off by ZPMC on this date. The QA Inspector also performed VT and MT for DP040-001 after ZPMC. The completed work appeared to comply with the contract specifications.

Later in the shift, the QA Inspector began final VT on DP041-001 and observed 130mm of overlap after repairs were attempted by ZPMC on weld joint 4. The QA Inspector measured the Y location beginning at 13,478mm. Also on DP041-001, weld joint 2, beginning at Y location 14,930mm, the QA Inspector observed approximately 30mm of under fill that was not repaired and appeared to be overlooked by ZPMC during repairs. These two areas were brought to the attention of ZPMC QC personnel Fu Yuhong and Caltrans QA Inspectors Steve Hall and Roscoe Dixon. Later in the shift, ZPMC personnel completed welding and grinding for the area where the under fill was observed and completed grinding in the area where the overlap was observed. Once these two areas were addressed, the remaining final VT and MT inspections were completed on second shift by QA Inspector Steve Hall.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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:	Carreon,Albert	QA Reviewer
