

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-002978**Date Inspected:** 20-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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 Yuhoung**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**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.

OBG-Bay 4

The QA Inspector performed final magnetic particle testing (MT) verification of three (3ea) critical weld repairs (CWR) that were completed 6/19/08 on the stiffener plate fillet welds for side panel designation SP414-001-005 (CWR #110), SP414-001-007 (CWR #111) & SP414-009 (CWR #112). The QA Inspector also performed MT for approximately 10% of the T-stiffener fillet weld joints on side panel designation SP181-001-008 through 012. No relevant indications were observed at the time of testing. The QA Inspector generated a TL-6028 report on this date.

OBG-Bay 7

The QA Inspector performed ultrasonic testing (UT) for approximately 10% of the complete joint penetration (CJP) weld splices on OBG diaphragm plate FB010-009, weld joint 023 and 026. The UT was performed within the area where the weld joints intersect. No relevant indications were observed at the time of testing. The QA Inspector generated a TL-6027 report on this date.

OBG-Bay 1

The QA Inspector performed MT for approximately 10% of the tack welded areas on deck panel DP542-001. The

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QA Inspector performed MT on the nine (9ea) tack welds on weld joint 006 and verified no apparent relevant indications.

Also in this bay, the QA Inspector observed the following deck panels located on gantry 1; DP582-001 (in-process), DP542-001 (idle), DP602-001 (complete), DP607-001 (complete). The QA Inspector observed DP331-001 (idle) located on gantry 2.

Other general observations by QA were as follows:

QA observed ZPMC has approximately 57 workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, hole drilling at ends of U-Ribs using a drill template, PJP bevel preparation, closed rib splice FCAW welding, closed rib diaphragm fit-up and FCAW welding, closed rib to deck plate fit-up and tack welding.



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.

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Inspected By:	Leach,Ed	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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