

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-003186**Date Inspected:** 27-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**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	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 1:

The QA Inspector performed Final Visual Inspection (VT) on the welds attaching U-Ribs to Deck Plate DP037-001 at Weld Joint (WJ) Numbers 001/002(U-112), 003/004(U-145) and 005/006(U-144). There appeared to be no indications. The QA Inspector did not sign off on Tag Number 000000106 per instructions from QA Inspector Roscoe Dixon and American Bridge/Fluor Enterprises Quality Inspector Warren Beuhler.

The QA Inspector performed Final VT on the welds attaching U-Ribs to Deck Plate DP037-001 at WJ's 001/002(U-129), 003/004(U-130), 005/006(U-124), 007/008 (U-125) and 009/010 (U-122). There appeared to be no indications. The QA Inspector did not sign off on Tag Number 0000000019 per instructions from QA Inspector Roscoe Dixon and American Bridge/Fluor Enterprises Quality Inspector Warren Beuhler.

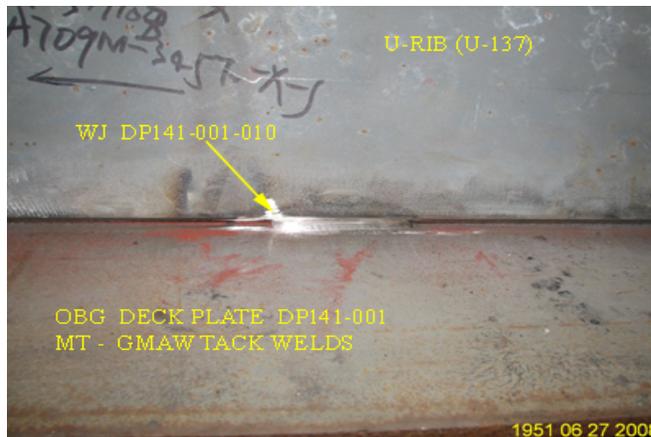
OBG Bay 1:

The QA Inspector performed a random 10% Magnetic Particle Testing (MT) of the Tack Welds welds attaching the U-Ribs to Deck Plate DP141-001 WJ's 001/002 (U-144), 003/004 (U-131), 005/006 (U-134), 007/008 (138) and 009/010 (U-137). Attached photographs provide additional detail. See corresponding 6028 for 06-27-08.

WELDING INSPECTION REPORT

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The QA Inspector performed a random 10% MT of the Tack Welds attaching the U-Ribs to Deck Plate DP617-001 WJ's 001/002 (U-224), 003/004 (U-200), 005/006 (U-229), 007/008 (U-194) and 009/010 (U-188). Attached photograph provides additional detail. See corresponding 6028 for 06-27-08.



Summary of Conversations:

There were no relevant conversations.

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 Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer