DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-003884
Date Inspected: 11-Sep-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1430
OSM Departure Time: 2000
Location: Shanghai, China

CWI Name: Zhang Bao Lei

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☐	☐	☑
Qualified Welders:	☐	☐	☑
Approved Drawings:	☑	☐	☐

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

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	OBG Panels	NA	NA	QCMT/QAMT

OBG Assembly: Caltrans QA inspector performed magnetic particle testing (MT). The subassembly is identified as edge plate EP005-001 welds 002, 003 004, 005, 006, 007, 008 and 009 cover pass welds. Caltrans OA inspector observed that the welds for the subassembly were in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 11, 2008 for additional information.

Bay 4: Caltrans QA inspector witnessed ZPMC perform QC-MT, after repair. The subassembly is identified as BP306-001, welds #005, 007 & 008 cover pass, per CWR 155 and ZPMC notification of witness inspection, document number 01015. ZPMC QC-MT inspector is identified as Mr. Xu Hai. ZPMC QC, at the conclusion of the testing, informed Caltrans QA inspector that the welds were accepted by QC and no relevant indications were observed.

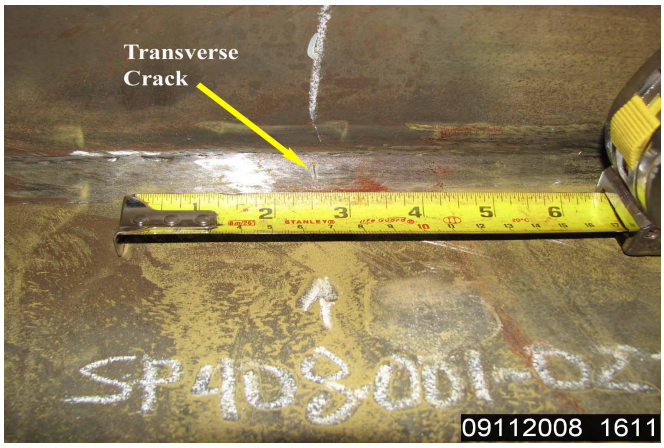
Caltrans QA inspector performed MT inspection of the bottom plate BP306-001, welds 005, 007 and 008 weld repairs. The welds were in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 11, 2008 for additional information.

Bay 4: Caltrans QA inspector is present to witness ZPMC QC perform MT, weld removal area per approved CWR 160 weld repairs. The subassembly is identified as side plate SP400-001, welds 041, 039, 032 and 031. The QCMT inspector is identified as Mr. Xu Hai. ZPMC QCMT inspector, at the conclusion of the inspection, informed Caltrans

QA inspector that the welds were accepted by QC and no relevant indications were observed.

Caltrans QA inspector performed MT inspection of the side plate SP400-001, welds 041, 039, 032 and 031. The weld removal area appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 11, 2008 for additional information.

Bay 4: Caltrans QA inspector witnessed ZPMC QC inspector, Mr. Bao Tin Rui perform magnetic particle/ testing per ZPMC notification of witness inspection, document number 01010. The subassembly is identified as side plate SP-408-001, welds 001, 002, 003, 004, 005, 006, 007, 008, 009, 010, 011, 012, 013, 014, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034 and 035 cover pass welds. ZPMC MT coverage consisted of 100% of the cover pass weld. However, at weld 027 ZPMC QC inspector, Mr. Bao Tin Rui observed a five millimeter transverse crack. The ZPMC QC informed Caltrans QA inspector that the transverse crack requires a critical weld repair (CWR) approval prior repairing the weld. The following digital picture illustrates the transverse crack.



Summary of Conversations:

As identified with in the contents of this 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 Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer