

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-000479**Date Inspected:** 14-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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:	89 Mock-Up	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 89 Mock-Up Plate P 213-1 to P 1235-1 weld #63 cover pass on the Up Side. Ultrasonic testing was witnessed being performed by E. Shuiqin and Li Xin Yong. Calibration was performed with a 0 degrees 2.5 MHz transducer for the lamination scanning by E. Shuiqin with no indications being noted. E. Shuiqin also calibrated the unit using a 70 degree transducer scanning both sides of the weld and heat affected areas with no relevant indications being noted. The ZPMC technician Li Xin Yong calibrated his UT unit with a 45 degree 2.5 MHz transducer and scanned the areas on each side of weld 63. One indication was observed 56 mm deep located at the edge of the weld, weld edge at the longest straight edge of the two plate. Light grinding was performed and retested with no indications being noted.

The Down Side of the plate was made accessible for UT testing and scanned with a 70 degree transducer by E. Shuiqin and with a 45 degree transducer by Li Xin Yong. No relevant indication were noted during the scanning by either technician.

Summary of Conversations:

There were no conversations pertinent to this project that took place during this shift.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Smith, David	Quality Assurance Inspector
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Reviewed By:	Cochran, Jim	QA Reviewer
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