

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-000485**Date Inspected:** 09-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:** Xu Fe Feng**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:** 114 Skin C,D&E**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 SA 13-1 to 1236-1 with a thickness of 75mm. Preheat in progress

Item-2 114 Skin-C Upper section cover pass on plate MP 1019-1 to MA 112-1 and Ma 112-1 to MP 1021-1. The ZPMC technician Cai Xin Xin was observed performing a dry powder Magnetic Particle (MT) test with the MT unit B310S SN-4804 & calibration due date of 5/27/2008 on the cover pass of side B plate weld MA 112-1 to on side B of plate MA 112-1 to MP 1019-1 with MT unit B 310S SN 4984 calibration due date of 5/27/2008. MT on both of the cover passes was MT/OK. Caltrans QA Inspector performed an MT test on approximately 25% of both of the cover passes of side B and was found to be in compliance with project specifications.

Item-3 114 Skin-D Upper Section. Plates MA 101-1 to MP 1014-1. An MT test was performed and witnessed on the tack welding of both sides of the stiffener plates MP 1006-2 and MP 1009-2. The tests were performed by ZPMC technician Zhou Dong Yun and was MT/OK. The Caltrans QA Inspector performed a dry powder MT test on approximately 25% of the tack welding of each side of each stiffener and was found to be in compliance with project specification. Present during these tests were (BV) CWI/QC Xu Fe Feng and ZPMC QA Fu Yu Yuhong.

Item-4 114 Skin-E Upper Section. An MT test was performed and monitored of the tack welding on plates MP 1023-1 to MA 109. The MT testing was conducted by ZPMC technician Cai Xin Xin using MT unit B310S, SN 4804 with a calibration due date of 5/27/2008 and was MT/OK. The Caltrans QA Inspector performed an MT test on approximately 25% of tack welds with no relevant indications being noted and was found to be in compliance with project specifications. The CWI/QC was (BV) Xu Fe Feng and the ZPMC QA was Fu Yu Yuhong.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

There were no pertinent conversations pertaining to the project 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.

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