

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-000698**Date Inspected:** 25-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**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:	114 Meter Mock-Up	

Summary of Items Observed:

This Quality Assurance (QA) Inspector observed ZPMC Ultrasonic Technicians Li Li Ming and E Shui Qin performing ultrasonic testing (UT) after heat straightening on the 114 Meter Mock-Up Interior Corner Splice Assembly MUC-116 complete joint penetration (CJP) welds between plates p918, p919 and A116. UT was being carried out from faces A and B, side 1. The weld numbers of the pieces being joined were 1 for p918 to A116 and 2 for p919 to A116. The areas tested were a total of 2450 millimeters (mm) in length on each weld. All welds tested were found acceptable in by Li Li Ming who used a 70 degree transducer & E Shui Qin who used both a Zero and 70 degree transducer. It was further observed that the angle of the transducers are still being calculated by the use of various measurements off of the International Institute Welding (IIW) block instead of using an IIW Block which has the markings for taking direct reading of the transducer angles. Upon completion and verbal acceptance of these two welds this QA Inspector performed 20% verification testing on each weld. For detailed report of QA's ultrasonic testing see TL-6027 dated October 25, 2007.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations held today.

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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
