

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-003940**Date Inspected:** 21-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**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:** Various (see below)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 2

QA verified the accuracy of the Caltrans QA generated tack weld assessment spread sheet to the markings on the material in the shop and that ZPMC completed repairs at tacked areas where cracks were previously discovered by Caltrans QA using the Phased Array Ultrasonic Test (PAUT) method on u-rib to deck plate Partial Joint Penetration (PJP) welds. QA observed the following:

DP-007-001 all areas identified on the material as "CR" have been repaired and UT'ed by ZPMC. QA noted that none of the 13 "Y" locations marked for repair on the material appeared to match the tack weld assessment spread sheet exactly. However, QA noted that all of the areas in need of repair were clearly identified on the material.

DP-006-001: all areas identified on the material as "CR" have been repaired and UT'ed by ZPMC. QA noted that all but 10 of the 38 locations marked for repair were clearly identified on the material. The other 10 "Y" locations were partially removed during the repair. QA noted that ZPMC has repaired one location that was clearly identified as "OK" by Caltrans QA on the material.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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