

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-003967**Date Inspected:** 14-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu Ming Kai	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:	OBG	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Bay 4:

The QA Inspector was requested by ZPMC QC, to observe Magnetic Particle Testing (MT) of Weld Joint (WJ) Numbers 001 through 006, 019 through 022 on Deck Plates DP734-001 and DP737-001 and 013 through 024 on Side Plate SP364-001. The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Zhao Dongyun utilizing the MT Method to examine 100% of the cover passes of the welds on the above listed Deck Plates DP734-001, DP737-001 and Side Plate SP364-001. There appeared to be no indications and ZPMC QC accepted the above listed welds.

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Zhao Dongyun utilizing the MT Method to examine 100% of the excavations of WJ's 026/027, 028/029 and 032/033 on SP407A (B-CWR158); WJ 032 on SP788A and SP789; WJ's 001 through 006 on DP633A and DP629A; WJ 055 on SP406 and WJ's 032, 033, 035, 038 and 041 on SP403A. There appeared to be no indications in the excavations on SP403A, SP406, DP629, SP788A and DP633A; and these items were accepted by Mr. Zhao. There were remaining indications observed by ZPMC QC in the excavations on SP407A and SP789. The QA Inspector observed that these excavations were inaccessible with an angle grinder and that a pencil grinder would have to be utilized to remove the indications in the excavations in SP407A and SP789. The attached photograph provides additional detail.

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The QA Inspector randomly performed a 10% MT final verification of the cover passes of the welds 001 through 006, 019 through 022 on Deck Plate DP734-001 and 013 through 024 on Side Plate SP364-001. There appeared to be no indications and the QA Inspector accepted the above listed welds. See TL 6028 for this date for additional detail.



Summary of Conversations:

As noted in the above body 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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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