

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-004081**Date Inspected:** 05-Oct-2008**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:	Chin Xi			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/ Tower		

Summary of Items Observed:

Visual inspection Verification

This QA inspector received verbal notification from ABF that tower double diaphragms for SSD1 at the 23, 38, 43 and 47.6 meter elevations are ready for final visual and NDT by Caltrans QA. This QA inspector performed VT review of the 38 meter double diaphragm for the south tower lift 1. Upon inspection of the weldments (approx half way through the VT) it was noted that there were areas of excessive grinding to the weld profile and areas of undercut along with non fusion of weld tie-ins. ABF rep was called to the location and verified the areas. ABF turned the component back over to ZPMC to complete the areas outlined and perform their VT again. Caltrans QA inspector continued with the VT on the 47.6, 23 and 43 meter diaphragms the VT was completed and areas were marked to be addressed. ZPMC "may" address these areas on the night shift or tomorrow on day shift. The QA MT still needs to be performed on these components along with the QA VT on the 38 meter diaphragm tomorrow on day shift. ZPMC is planning on erecting these components tomorrow 10-6-08.

Witness of CWR's Tower shop 2 and OBG 4

This QA inspector observed ZPMC performing excavation and MT on 2 CWR's. 1) T-CWR025 at the east tower lifts 1 double diaphragm plate. The plate was 20mm to short and required additional welding to bring into tolerance. ZPMC performed MT testing that was witnessed by this QA inspector and observed the area (and relayed to this QA from ZPMC) to be within compliance. 2) B-CWR177 at side plate SP408A-001 weld number 027. A transverse crack was discovered at this location upon arrival ZPMC had excavated this area and was performing the MT for excavation. This QA inspector witnessed the MT and verified that the crack had been completely removed.

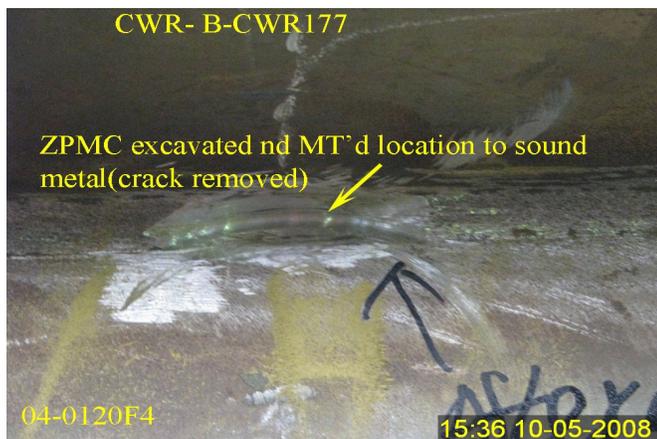
Deck panel repair area 2 (yard)

This QA inspector received information from ZPMC and day shift inspectors that 5 deck panel plates needed areas

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identified and marked by Caltrans QA for Radiographic Testing (RT). This QA inspector marked the areas each measuring 300mm in length for ZPMC to grind flush in preparations of the RT testing. The Deck panels marked were Dp121-002, DP229-001, DP418-001, DP175-001 and DP472-001.



Summary of Conversations:

As noted above.

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 Josh Ishibashi 1-376-471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
