

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-004088**Date Inspected:** 10-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:** Liu Yang**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:** Tower**Summary of Items Observed:**

Green Tagging

This QA inspector along with ZPMC and ABF personnel signed the ABF green tag documentations for the skin plate to stiffener welds only for component SSD1-Skin E. It was noted on their documentation by the Caltrans QA inspector that this was per ABF's documentation only and Caltrans completed review of the above component.

MT inspection Verification

This QA inspector received verbal notification from ZPMC QC department and Caltrans QA day shift personnel that tower Skin plate SSD1-Skin E was ready for the Caltrans QA verification. This QA inspector arrived in tower shop 1 and observed ZPMC in process for the MT and UT inspections. This Caltrans QA inspector observed ZPMC mark several linear indications from the MT inspection and had additional personnel grind these areas that were identified; upon completion ZPMC re-evaluated these areas and found them to be acceptable with no further indications. This Caltrans QA inspector then proceeded to perform a random QA review for 10 % of the total weldments of stiffener plate to skin plate PJP weldments. Upon completion of the QA review it was noted that the weldments appeared to be within compliance of the contract documentation at the time of the QA review. A TL-6027 will be generated for these areas.

Additional MT was performed in tower shop 1 for SSD1- SA208 A/D-3&4 B weldments. These welds were completed and accepted by ZPMC prior to this QA inspector performing his review. During the QA review one area on weld SSD1-SA208 A/D- 3B a linear indication was discovered approximately 2mm in length, ZPMC ground the surface area of this location and MT was performed by this QA inspector again and found no linear indication. The weldments were completed and appeared to be within compliance of the contract documentation at the time of the QA review. A TL-6028 will be generated for these locations.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
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Reviewed By:	Carreon, Albert	QA Reviewer
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