

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-004149**Date Inspected:** 20-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:** 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:

Tower bay 1

Caltrans QA inspectors Steve Hall and Larry Viars were requested to perform Visual Testing (VT) and Magnetic particle Testing (MT) after ZPMC tested and accepted the south tower longitudinal stiffener connection plate PJP welds on skin plate D (ZPMC NDT notification no. 001243). During the VT Mr. Viars observed what appeared to be areas of overlap, slag inclusions, and "crack like" linear indications. Three welds were chosen by QA for MT. All three welds appeared to have non-conforming "crack like" linear indications. These areas were shown to Mr. Mike Williams with American Bridge Fluor (ABF). Mr. Williams concurred with QA and stated that both ZPMC and ABF would re-do the VT and ZPMC would re-MT all of these welds. See the attached photos below of the South Tower connection plate PJP weld identified as SSD1-SA180 A/E # 34.

QA performed UT on the following weld joints:

SSD1-SA163A/D-18A, SSD1-SA163A/D-17A, SSD1-SA163A/D-1A, SSD1-SA171C/D-42B,

SSD1-SA171C/D-41B, SSD1-SA171A/D-9B, SSD1-SA171A/D-6B, SSD1-SA171C/D-34B and

SSD1-SA171C/D-33B. All welds scanned appeared to conform to AWS D1.5 2002 and the contract documents.

WELDING INSPECTION REPORT

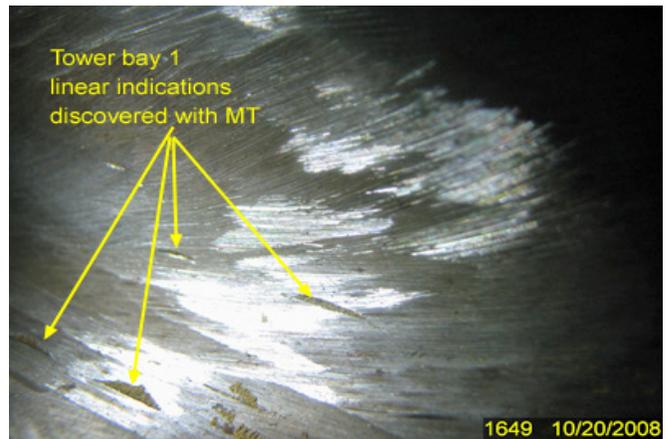
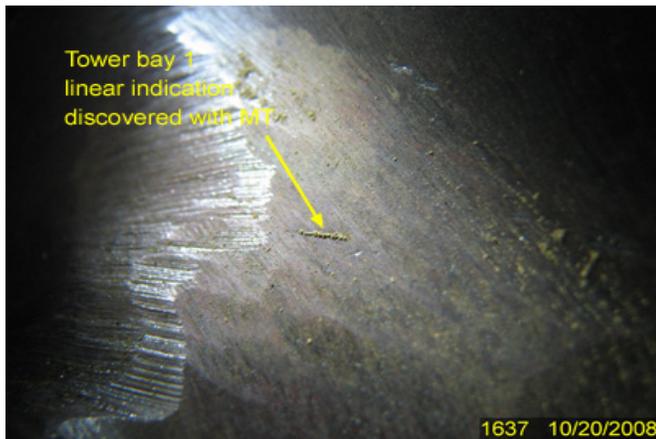
(Continued Page 2 of 2)

OBG bay 4

QA received NDT notification document no. 001242 from ZPMC QC and performed 10% verification MT on the following weld joints:

Notification no. 001242

SP-440-001-001~010, SP-431-001-001~010, SP-610-001-013~024 and SP-530-001-001~014. All welds tested appeared to comply with AWS D1.5 2002 and the contract documents.



Summary of Conversations:

As stated 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 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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