

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-004266**Date Inspected:** 25-Oct-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:** Shangxing Island, Shanghai

CWI Name:	N/A	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:	Deck panel	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panel DP576-001

1. The QA Inspector performed Ultrasonic Testing (UT) using the gate to gate technique on the horizontal partial joint penetration welds made on the U-ribs (four ribs two welds per rib eight welds total) on the deck panel identified as DP576-001. The QA Inspector performed the ultrasonic testing on the tack weld areas only a total of 224 tack welds were made on the eight welds. The QA Inspector performed the testing on the weld number two through eight on this date. The QA Inspector observed a total of nineteen linear indications on the tested weld areas on this date and the indications observed were marked on the steel for phased array ultrasonic testing investigation that will be performed at a later time. Please see the QA Inspector's log generated on this date for additional information regarding amount of indications and locations. The QA Inspector's log is available for review as requested. The QA Inspector completed the testing on the tack welds on weld number three through eight and the testing was not completed on the weld number one and two on this date. The QA Inspector notified Task Leader Albert Carreon of observations during testing.

2. The QA Inspector was requested to perform ultrasonic testing using the gate to gate technique on the tack weld areas on the partial joint penetration welds made on the U-ribs on the deck panel identified as DP179-001 and

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DP474-001. The QA Inspector was notified these deck panels were taken priority and that the testing needed to be complete as soon as possible. The QA Inspector could not locate the mentioned deck panels and requested ZPMC Quality Control personnel to provide the QA Inspector with information regarding the location of the mentioned deck panels. Later during the shift the ZPMC Quality Control personnel notified QA Inspector the deck panels were located outside of facility and were not be accessible to perform any testing. The QA Inspector notified Task Leader Albert Carreon and Lead QA Inspector Paul Dawson of none availability testing for the requested deck panels.

Summary of Conversations:

As noted within the body of the report 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 Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
