

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-004267**Date Inspected:** 11-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/OBG**Summary of Items Observed:**

UT Tower bay 3

This Caltrans QA Inspector arrive at ZPMC to perform UT verification for deck plate CJP weld DP600-001-300 for 10% of the weld length after ZPMC had completed and accepted the weld. This Caltrans QA inspector found the weldment to be within compliance at the time of review. Two additional weldments were tested by ZPMC and were found to have rejectable indications in them. The weld numbers were DP555-001-300 and DP610-001-300.

VT and MT tower skin plate D

Caltrans QA inspectors visually and magnetically inspected all accessible welds for the first 3 Meters of skin plate SSD1-Skin D for the stiffener to skin plate weldments. The Caltrans QA inspector identified areas for ZPMC to perform the necessary repairs. Upon completion of the repaired areas Caltrans QA Inspector performed 10 % MT for this location which appeared to be within compliance.

UT verification tower shops 1 and 2

This Caltrans QA Inspectors performed random 10% QA verification for tower components after ZPMC had completed and accepted the CJP weldments. Weld numbers SSD1-SA171 A/D-1 and 2 were completed for the QA verification. At the time of QA review the weldments appeared to be within compliance according to the contract documents. Caltrans QA Inspectors performed random 10% QA verification for tower components after ZPMC had completed and accepted the CJP weldments.

Summary of Conversations:

no conversations today.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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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