

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004338**Date Inspected:** 27-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 plate and Floor beam	

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:

U-Rib # DP472

1. The QA Inspector performed Ultrasonic Testing (UT) on the weld repaired area made on the complete joint penetration butt splice weld between the 12 millimeters thick U-rib assigned for the deck panel identified as DP472-001. The QA Inspector also performed additional ultrasonic testing on the butt splice weld after the ZPMC Quality Control personnel reported the weld to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on the butt weld mentioned above. The QA Inspector notified Task Leader Albert Carreon of the QA Inspector's UT verification. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

Floor Beam FB040-002

2. The QA Inspector performed random Ultrasonic Testing (UT) on the complete joint penetration butt splice welds (a total of four welds) made on the floor beam plate assigned for the assembly floor beam identified as FB040-002. The QA Inspector performed the ultrasonic testing on the butt welds after the ZPMC Quality Control personnel reported the welds acceptable and ready for verification. The QA Inspector did not observe any rejectable welding

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discontinuities on the tested weld areas. The QA Inspector notified Task Leader Albert Carreon of the QA Inspector's UT verification. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

Floor Beam FB039-002

3. The QA Inspector performed random Ultrasonic Testing (UT) on the complete joint penetration butt splice welds (a total of four welds) made on the floor beam plate assigned for the assembly floor beam identified as FB039-002. The QA Inspector performed the ultrasonic testing on the butt splice welds after the ZPMC Quality Control personnel reported the welds acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on the tested weld areas. The QA Inspector notified Task Leader Albert Carreon of the QA Inspector's UT verification. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

4. The QA Inspector was requested to perform ultrasonic testing on the complete joint penetration butt welds (a total of four welds) on the identified assembly number SSD1-SA224 A/B-2A/B through 9A/B. At the time of the QA Inspector's arrival at the location the QA Inspector observed that the ZPMC Quality Control Inspector personnel had performed 100 percent testing on the welds and reported a rejectable indication on the weld number SSD1-SA244 A/B-2. The QA Inspector was notified by the ZPMC Quality Control Inspector personnel weld repair operation will be performed on this weld at a later time and after repair was acceptable the QA Inspector could perform verification. Please note that the weld repair was not performed on this weld during the QA Inspector's shift on this date.

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
