

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-004341**Date Inspected:** 06-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Tai**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:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Heavy Shop 1**Ultrasonic Testing**

The Quality Assurance Inspector performed 25% random ultrasonic testing verification on skin plate welds. The Quality Assurance Inspector performed the testing on the following welds; SSD1-SA61 A/G 16B, SSDI-SA61 A/G-5B, SSDI-SA61 A/G 13B, SA61-A/G 4B, SSDI-61 A/G 10B, SSD1-SA A/G-3A, and SA61 A/G 17B. See Caltrans report TL-6027 Ultrasonic Testing Report, dated October 6, 2008 for additional information.

Heavy Shop 2**Skin Plate E East Tower**

The Quality Assurance Inspector observed ZPMC Caltrans approved welders 0040614, utilizing the shield metal arc welding (SMAW) process on a complete joint penetration joint joining the 43 meter diaphragm to skin plate E to skin plate A East weld # ESD1-A165 G/J-13. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-4313-TC-P4-1.

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ZMPC grinding the cover pass on several skin plate assemblies in both Tower Shops. QA observed ZPMC performing fit up operations on various longitudinal stiffener assemblies.

Summary of Conversations:

No relevant conversations on this date.

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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
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Reviewed By:	Wright, Mark	QA Reviewer
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