

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-004412**Date Inspected:** 22-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:** Lie Yun, Peter Shaw**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:** OBG**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 OBG.

Bay 1

The Quality Assurance Inspector observed ZPMC personnel in process grinding tack welds DP422-001 prior to having ZPMC Quality Control perform magnetic particle testing.

The Quality Assurance Inspector observed ZPMC in process gas metal arc welding process on tack welds and fitting up operation U-ribs to DP351.

BAY 3

The Quality Assurance Inspector observed ZPMC in process welding and fit up operation on stiffener to side plate assemblies SP538. The Quality Assurance Inspector observed heat straightening operations being performed by ZPMC personnel on side plate SP537.

BAY 4

QA performed MT on Double Diaphragm Assemblies West 33meter and North 43meter
Both assemblies were green tagged.

Magnetic Particle Test

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The Quality Assurance Inspector performed 25% random magnetic particle testing verification and green tagging operations on double diaphragm tower assemblies West 33 meter and North 43 meter. The Quality Assurance Inspector performed 25% random magnetic particle testing verification and green tagging operations on bottom plate # BP093-001-001. The Quality Assurance Inspector green tagged BP093-001-001 and the North 43 meter double diaphragm plate assembly. See Caltrans report TL-6028 Magnetic Particle Test Report, dated October 22, 2008 for additional information.

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
Reviewed By:	Wright, Mark	QA Reviewer
