

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-004425**Date Inspected:** 11-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Bay 4:

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Xu Hai perform a final 10% Magnetic Particle Testing (MT) examination of the fillet welds on BP119-001 (BP119A-Yellow Tag # 000981) WJ's 007 through 018. Reject on WJ 013 ground into base metal of Bottom Plate to 3 mm. The QA Inspector also randomly observed ZPMC NDT Technician Xu Hai perform a final 10% MT examination of the fillet welds on Side Plates SP101-001 (SP101A-Yellow Tag # 000980) and SP484-001 (SP484A-Yellow Tag # 000983). There appeared to be no indications and ZPMC QC accepted the above listed welds.

The QA Inspector performed a final 10% random Magnetic Particle Testing (MT) verification of the fillet welds on Side Plates SP101-001 (SP101A-Yellow Tag # 000980/Green Tag 001045) and SP484-001 (SP484A-Yellow Tag # 000983/Green Tag 001046). There appeared to be no indications and the QA Inspector accepted the above listed welds. Green Tag Documentation was signed and dated by ZPMC Representative Chen Chih Chien, ABF Representative Hu Gui Hua and CT QA Inspector Lot Number B75.

Summary of Conversations:

As noted in the above body of this report.

WELDING INSPECTION REPORT

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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, 13764710411, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer