

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-004426**Date Inspected:** 19-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: Wu Ming Kai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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:**

The Caltrans 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 1:

The QA Inspector randomly observed 1 ZPMC magnetic drill operator and 2 drill press operators drilling bolt holes in OBG U-Rib connection plates.

OBG Bay 2:

The QA Inspector randomly observed 1 ZPMC drill press operator drilling bolt holes in T-Rib connection plates.

OBG Bay 3:

The QA Inspector randomly observed ZPMC welder Xiao Lin ID 049485, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2F (Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-2112-FCM, to tack weld I-Ribs to Side Plate SP443-001 Weld Joint (WJ) Numbers 001/002. The QA Inspector randomly observed ZPMC QC under the supervision of ZPMC CWI Wu Ming Kai, monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

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OBG Bay 4:

The QA Inspector randomly observed ZPMC NDT Technicians Xu Hai, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT Inspection of the cover pass on Side Plates SP518-001 (SP518A-Yellow Tag 001094), SP756-001 (SP756A-Yellow Tag 001092) Weld Joint (WJ) Numbers 013 through 024. There appeared to be no indications and ZPMC QC accepted all welds.

The QA Inspector performed a 10% MT verification of the cover pass of the fillet welds on Side Plates SP518-001 (SP518A-Yellow Tag 001094/Green Tag 001102), SP756-001 (SP756A-Yellow Tag 001092/Green Tag 001101) WJ Numbers 013 through 024. There appeared to be no indications and the QA Inspector accepted the above listed welds. The QA Inspector signed off on the ZPMC Green Tag Documentation after ZPMC Representative Xu Xian Ping and ABF Representative Yu Kun Ming signed.



Summary of Conversations:

As noted in the above body of this report.

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
