

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-004473**Date Inspected:** 24-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:** Shanghai, China

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 panels, stiffener connection plates**Summary of Items Observed:**

Heavy Duty Machine Shop - Bay 3

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed initial VT on deck panels DP136-001 and DP324-002. QA Inspector concurred with the apparent indications already marked in soapstone. QA Inspector observed that each of the panels had been marked in the initial VT area on the yellow tag by ZPMC CWI Sun Bo and an unidentified ABF representative.

QA Inspector performed final MT verification, 10% of the total linear distance of the 10% final MT performed by ZPMC on deck panels DP298-001, DP487-001, DP581-001, and DP601-001. No apparent indications were observed.

Heavy Bay 1

QA Inspector responded to a request by ABF QC Manager Mike Williams to witness ZPMC perform final MT on the 14 stiffener to stiffener upper connection plates on SSD1- skin assembly D. QA Inspector arrived at the noted skin assembly at the requested time of 1900 hours. ABF QC Don Walton was present, but after 30 minutes no ZPMC representative had arrived. QA Inspector chose one of the 28 welds, performed random MT, and observed eight indications in the first 300mm. QA Inspector reported this to shift leader Albert Carreon, who subsequently called ZPMC QC Ken Zhang (ZPMC QC). ZPMC QC arrived at the noted skin assembly and began instructing workers. QA Inspector left the area. At approximately 2000 hours, ZPMC QC called QA Inspector and requested QA Inspector to MT the same area where the indications were observed earlier. QA Inspector observed that some grinding had been performed, however no evidence of any ZPMC MT having been performed after the grinding. QA Inspector informed ZPMC QC that ABF QC Manager Mike Williams and ABF QC Don Walton had informed QA Inspector that ZPMC had not performed the required MT after the required 48 hour waiting period following

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the welding.

Summary of Conversations:

As noted in Summary.

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, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
