

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-004732**Date Inspected:** 16-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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:** Liu Wei Wei**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:** floor beams, side panels**Summary of Items Observed:**

Sub-assembly Shop- Bay 4

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final 100% VT and 10% MT verification of the total linear distance of the 10% final MT performed by ZPMC on SP487-001. No apparent indications were observed. QA Inspector noted agreement with ZPMC and ABF acceptance of the above on the yellow sticker attached to the component. QA Inspector also notated QA acceptance (per ABF documentation) on a document presented to QA Inspector by ABF QC Hu Gwi Hua.

QA Inspector performed final 100% VT and 10% MT on SP430A, including 100% MT at CWR #B-CWR 189 on (3 locations). No apparent indications were observed. Inspector noted agreement with ZPMC and ABF acceptance of the above on the yellow sticker attached to the component. QA Inspector also notated QA acceptance (per ABF documentation) on a document presented to QA Inspector by ABF QC Hu Gwi Hua.

Sub-assembly Shop- Bay 7

QA Inspector performed final 100% VT on FB011-013-045A. QA Inspector observed an excavation approximately 6mm into the base metal of the rib and approximately 8mm into the base metal of the floor beam plate. QA Inspector rejected this weld based on the above. QA Inspector did not note acceptance of the above on the yellow sticker attached to the component but indicated on the floor beam main plate acceptance of all others tested. QA Inspector immediately notified ZPMC CWI Liu Wei Wei and ABF QC Wang Wen Bin.

QA Inspector performed final 100% VT and 10% MT verification of the total linear distance of the 10% final MT performed by ZPMC on FB016-020B, FB009-012B. No apparent indications were observed.

QA Inspector performed final 100% VT and 10% MT of the total linear distance of the 10% final MT performed by ZPMC on FB009-018B. QA Inspector observed an excavation approximately 8mm into the base metal of the rib and approximately 10mm into the base metal of the floor beam plate. QA Inspector rejected this weld based on

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the above but indicated on the floor beam main plate acceptance of all others tested. No other apparent indications were observed. QA Inspector did not note acceptance of the above on the yellow sticker attached to the component. QA Inspector immediately notified ZPMC CWI Liu Wei Wei and ABF QC Wang Wen Bin.

Summary of Conversations:

As noted above 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 Peter Dautermann, 150-0219-9593, who represents the Office of Structural Materials for your project.

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