

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004744**Date Inspected:** 20-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Deck Panel Tower	NA	NA	QA-UT
2	OBG Edge & Side Plates OBG	NA	NA	QA-UT

Heavy Shop 3: Caltrans Quality Assurance (QA) inspector performed conventional ultrasonic test (UT), gate to gate inspection of the tack welds joining u-rib to deck plate. The deck panel is identified as DP360-001. The UT inspection of the tack welds was initially started by Caltrans swing-shift inspector, Mr. Ricardo Medina and completed by night-shift inspector. The UT inspection performed by the Caltrans QA inspectors was preliminary UT inspection prior to using the phased array UT system to verify indications found by the conventional ultrasonic test inspection. This Caltrans QA inspector completed the UT inspection of deck panel tack welds for welds 009 and 010. This Caltrans QA inspector recorded Y-locations for indications found for welds 001, 002, 003, 004, 005, 006, 007, 008, 009 and 010 during the UT inspection of the tack welds. See Caltrans U-Rib to Deck Panel- Tack Weld Assessment Record, dated 11-20-2008 for additional information.

Caltrans QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Bay 3: Caltrans QA inspector performed ultrasonic test (UT) inspection per Caltrans swing-shift inspector, Mr. Ken Riley. The subassemblies are identified as OBG edge plate EP094-001, weld 001, edge plate EP062-001, weld 001

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and side plate SP466-001, weld 041 complete joint penetration (CJP) plate splice welds. Caltrans QA inspector observed that the welds have been UT inspected and accepted by ZPMC QC. Caltrans QA-UT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 20, 2008 for additional information. The following digital picture illustrates inspected FB094-001-001 weld.



Summary of Conversations:

As identified within the contents 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 Peter Dautermann, 150-2019-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
