

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-004801**Date Inspected:** 28-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Le	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:	various	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

QA performed material check test sampling for batch numbers 159 and 160 for the following plate heat numbers: (batch# 159) 07302863N0 (T=18mm), 07303374N0 (T=30mm), 7206432N (T=40mm), 7206357N (T=40mm). (batch# 160) 08201798N1 (T=40mm), 08201796N1 (T=60mm) and 08100406N0 (T=70mm). A total of 16 plates were sampled. QA indicated the Direction Of Roll (DOR) and wrote this QAs lot number on each sample. This QAs lot number was recorded on the Caltrans check test sample form for each heat number and is on file in the Caltrans QA office. ZPMC QA representative identified as Miss Wu Ming was present during the check sampling.

Tower bay 1

QA received Non Destructive Testing (NDT) notification document no. 001505 from ZPMC QC and attempted to perform 10% verification Ultrasonic Testing (UT) on the following weld joints:

NSD1-SA17A/G-17A/B, NSD1-SA17G/G-58A/B and 59A/B, NSD1-SA179A/E-3A/B, NSD1-SA179D/E-10A/B, 24A/B and 25A/B.

None of the above mentioned welds had been UT'ed by ZPMC on this date. Some of them appear to have been UT'ed last month however it is unclear as to whether they were accepted or rejected. ZPMC QC and ABF QC that

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were available in this bay could not produce any evidence of the acceptability of these welds. QA did not UT these welds tonight.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
