

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-004825**Date Inspected:** 29-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:	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:	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:

OBG sub assy bay 8

QA received Non Destructive Testing (NDT) notification document no. 001509 from ZPMC QC and performed 10% verification Ultrasonic Testing (UT) on the following weld joints:

(Floor beam)

FB020-006-080, FB020-005-080, FB028-010-080, FB028-009-080, FB019-005-080, FB027-009-080,

FB027-010-080.

QA noted that all welds had been tested and accepted by ZPMC UT technicians prior to QA testing. All welds tested by QA appeared to be compliant.

NOTE: The above mentioned NDT was not for green tag however, QA representative Mr. Shen Xuejun informed this QA that ZPMC personnel would be stacking these floor beam webs later in the shift making them inaccessible for Caltrans QA verification NDT.

OBG sub assy bay 4

QA received verbal notification from ZPMC QA representative identified as Mr. Shen Xuejun concerning

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green tag Magnetic particle Testing (MT) on tower diaphragm identified on the material as WSD1-43M. No written NDT notification was received from ZPMC. QA performed 10% verification MT on the following weld joints:

(43M west tower double diaphragm)

WSD1-SA234B/B welds 8, 6, 13, 14, 16, 15, 18, 12, 1, 3, 9, 11, 2, 4, 7 and 5.

WSD1-SA234A/B welds 1 and 2.

WSD1-SA268 welds 15, 13, 11, 12, 10, 14, 1 and 2.

QA noted that all welds had been tested and accepted by ZPMC MT technicians prior to QA testing. All welds tested by QA appeared to be compliant.

QA signed off on green tag# 001552 for the above mentioned diaphragm.

Summary of Conversations:

As mentioned above.

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
