

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-004912**Date Inspected:** 03-Dec-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:

Tower bay 1

QA received Non Destructive Testing (NDT) notification document no. 001538 from ZPMC QC and performed 10% verification Magnetic particle Testing (MT) on the following weld joints:

SSD1-SA164D/F 2,3,5,6,10,11,14,15,18,19,21,22,26,27,29 and 30.

SSD1-SA164E/F-2,3,5,6,11,12,14,15,18,19,26,27,28,29,32 and 33.

All welds tested appeared to be compliant. QA signed green tag #1007 for the above mentioned stiffener welds along with ABF QC inspector identified as Mr. Yang Yi Heng.

OBG sub assembly bay 7

QA received Non Destructive Testing (NDT) notification document no. 001533 from ZPMC QC and performed 10% verification Magnetic particle Testing (MT) on the following weld joints:

FB019-003-022~067,071,072,077,086~088, 093, 106, 107, 111, 114, 120, 121, 123~127, 130~133,136~141, 144, 145,148,150 and163. All welds tested appeared to be compliant

ABF QC inspector identified as Mr. Wei Jian Bo translated to QA from ZPMC shop personnel that items 1 thru

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6 (FB006) on the above mentioned NDT notification (001533) had been MT'ed and accepted by ZPMC and Caltrans QA. Mr. Wei Jian Bo informed this QA that the items had been removed from this bay and are being sandblasted.

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
