

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-004963**Date Inspected:** 10-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chin Ming**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:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 7**Ultrasonic Testing**

The Quality Assurance Inspector performed 10% random ultrasonic testing verification on floor beam assemblies. The Quality Assurance Inspector performed the testing on the following welds; FB024-004-078 thru 081, 101, 108, 117, 122, 021, 125 thru 127, and 147. See Caltrans report TL-6027 Ultrasonic Testing Report, dated Dec. 10, 2008 for additional information.

Ultrasonic Testing

The Quality Assurance Inspector performed 10% random ultrasonic testing verification on floor beam assemblies. The Quality Assurance Inspector performed the testing on the following welds; FB023-003-148. See Caltrans report TL-6027 Ultrasonic Testing Report, dated Dec. 10, 2008 for additional information. Floor Beam FB 023-003-148 was green tagged by the QA. QA verified the VT, MT, and UT was completed by Caltrans QA Inspectors before green tagging.

Bay 1**DP589-002**

The Quality Assurance Inspector observed ZPMC welder 059416, utilizing the gas metal arc welding process on a

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partial penetration weld joint on DP589-002. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

DP589-002

The Quality Assurance Inspector observed ZPMC welder 059361, utilizing the gas metal arc welding process on a partial penetration weld joint on DP589-002. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

The Quality Assurance Inspector observed ZPMC personnel in process of performing gas metal arc welding process on tack welds on DP604-001.

The Quality Assurance Inspector observed ZPMC personnel in process of performing grinding operations on tack welds for DP574-001. The tack welds are being ground in an effort for ZPMC Quality Control to perform magnetic particle testing.

The Quality Assurance Inspector observed ZPMC Fitters in process of chalking u-ribs layout on DP569-001 in effort to aid in the fit up of u-rib.

Outside Area of the Bay 1

The Quality Assurance Inspector observed ZPMC, has staged several deck panels outside without sealing leaving the u-rib diaphragm plate to the deck panel open for water entrapment.

Summary of Conversations:

No relevant conversations on this date.

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:	Lara, Raymond	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
