

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-004977**Date Inspected:** 02-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island, Shanghai

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:	OBG and tower components	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

OBG floor beam.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed welds made between assembly component members on the inspection part number: FB011-011, FB009-010, FB016-021, FB009-011, FB024-005 and FB020-003 of the OBG floor beam section (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001520 item numbers 4 to 8 and document number 001526 item numbers 1 to 5 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspector Wu Bin and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

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Deck panel.

2. The QA Inspector performed a random VT and MT verifications on the completed welds made between assembly component members on the inspection part number: DP654A-001 and DP646A-001 of the tower section (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001528 item numbers 1 and 2 for weld numbers. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Summary of Conversations:

As noted in the body of the report 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 Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
