

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-005683**Date Inspected:** 03-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the paint shop)

Segment 4BW

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel transverse stiffeners in way of the crossbeams. The Weld Designations are as follows: SEG019E-015, SEG019E-018, SEG019E-030, SEG019E-041, SEG019E-061, SEG019E-064, SEG019D-015 and SEG019D-018.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the longitudinal diaphragm attachment to the floor beam web plate. The Weld Designations are as follows: SEG19B-003, SEG19B-020, SEG19B-022, SEG19C-002, SEG19C-015 and SEG19C-017.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the lifting lugs at panel point 27. The Weld Designations are as follows: SSD11A-PP27-220 and SSD11A-PP27-240.

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This QA Inspector performed Magnetic particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the corner assembly welds. The Weld Designations are as follows:

SEG019G-001, 004, 005, 008, and SEG019F-001

CA011-35, 36, 37, 39, 47, 48, 49, 59, 60, 61, 63, 71, 72, 73, 75, 109 and 110.

CSD2-PP27.5-9, 10, 11, 12, 13, and 14.

CSD4-PP27-001, 002, 003, 004, 005, 065, 007, 008, 009, 010, 011 and 012.

CSD3-PP28-63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73 and 74.

CSD2-PP28.5-9, 10, 11 and 12.

CSD2-PP26.5-9, 10, 11, 12, 13, 14, 27, 28, 21 and 22.

CSD3-PP26-63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73 and 74.

During random verification Magnetic Particle Testing of corner beam assembly weld # CSD3-PP26-64, Caltrans Quality Assurance (QA) Inspector discovered 40mm long linear indication previously overlooked by ZPMC Quality Control MT Technicians. See Incident report for this date.

Summary of Conversations:

No Relevant conversations



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 Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
