

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005999**Date Inspected:** 18-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Wei Ping**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:** Segments 1AW & 1AE**Summary of Items Observed:**

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

OBG Assembly Bays 1, 2 & 3

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) welds on OBG floor beam assemblies designated as 1AW & 1AE. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. The weld identification numbers are as follows:

CB203F-001-3

CB203F-001-4

CB203F-001-7

CB203F-001-8

DP525-001-001

DP525-001-011

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

DP525-001-028
DP525-001-021
DP525-001-029
DP525-001-020
DP525-001-095
DP525-001-096
DP525-001-097

DP526-001-098
DP526-001-095
DP526-001-093
DP526-001-020
DP526-001-025
DP526-001-100
DP526-001-019

DP524-001-016
DP524-001-065

DP526-001-099
DP526-001-112
DP526-001-013
DP526-001-031
DP526-001-014
DP526-001-032
DP526-001-087
DP526-001-088
DP526-001-089

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records to this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------