

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-006904**Date Inspected:** 26-May-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 (South of the blast shop)

Segment 5CW

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 floor beam sub-assembly component welds. The Weld Designations are as follows:

FB004-009-042.

FB004-006-042.

FB009-002-021.

FB015-009-023.

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 edge plate to the side and bottom plate welds. The Weld Designations are as follows:

CA021-003 and 004.

CA022-003 and 004.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and

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accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the side plate splice welds. The Weld Designations are as follows: SEG025A-009 and 010.

Segment Repair Yard (North of the blast shop)

Segment 6BE

This QA Inspector performed a preliminary random visual inspection of the internal structure of this segment. Areas that were marked to be ground and welded were repaired at the time of inspection. During visual inspection of the internal components of this segment, Caltrans Quality Assurance (QA) Inspector discovered the following fabrication issues by Visual Testing (VT) on welds previously inspected and accepted by ZPMC Quality Control (QC) and ABF QA Inspectors.

1. All welds connecting the floor beam web plate to the bottom and side plates have fillet welds wrapped on both ends of the cut out for T-rib stiffeners. The weld detail on drawing shows the fillet weld is to be welded both sides and not welded all around (wrapped).

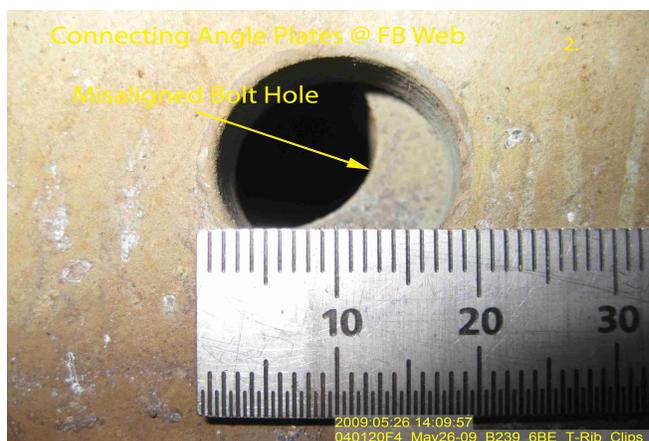
2. The connecting angle plates, for the T-rib to floor beam web bolted connection were found to be misaligned in a total of nine (9) locations throughout the segment. The misalignment was measured to be between 5mm to 15mm.

3. The radius cut outs for the deck panel rib stiffeners were found to be misaligned in way of corner assembly 28A at panel point 42.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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.

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