

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006971**Date Inspected:** 07-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 Fabrication**Summary of Items Observed:**

CWI Inspectors: N/A

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Prior to Caltrans QA Inspectors' concurring with issuance of OBG deck plate closed rib green tag releases a review of the ultrasonic inspection database is performed to verify all closed rib tack weld repair locations have been ultrasonically accepted. Today this QA Inspector, Mr. Paul Dawson, performed data entry of ultrasonic inspection information from the field generated Ultrasonic inspection data sheets onto the common drive computer database for the following OBG deck panels: DP258-001, DP288-001, DP093-001, DP396-001, DP420-001, DP421-001 and DP395-001.

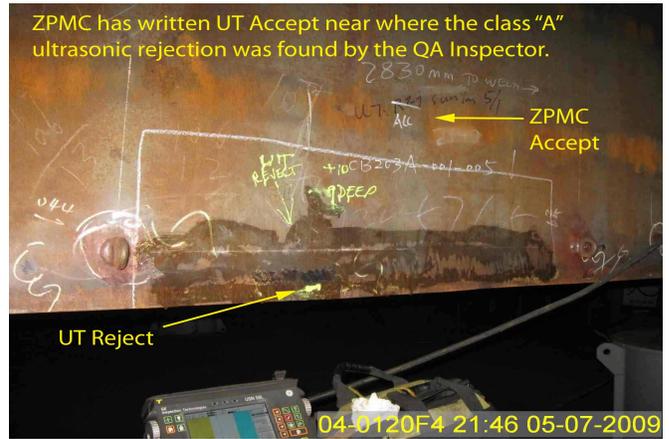
Outside Yard

ZPMC issued an "Inspection Notification Sheet" #2964 requesting QA to green tag Cross Beam CB1 and that various welds are ready for ultrasonic inspections. This QA Inspector performed ultrasonic inspections of various welds listed on the notification. This QA Inspector performed random ultrasonic inspections of the following welds: CB203A-001-004, CB203A-001-016, CB203A-001-017, CB203A-001-018, CB203D-001-006, CB203D-001-010, CB203F-001-006, CB203F-001-010, CB203E-001-002, CB203E-001-003, CB203E-001-004,

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CB203E-001-006, CB203E-001-007, CB203E-001-008, CB203E-001-009, CB203E-001-011, CB203D-001-002, CB203F-001-002 and CB203A-001-005. All welds appear to comply with project specifications and welds CB203D-001-002, CB203F-001-002 and CB203A-001-005 SP215-001-042 all appears to have class "A" (Rejectable) ultrasonic indications. All of these welds had previously been previously been ultrasonically inspected and accepted by ZPMC inspection personnel. This QA Inspector informed ZPMC QC representative Mr. Fu Yuhong that weld the three welds listed above appear to be ultrasonically rejectable and Mr. Fu Yuhong informed this QA Inspector that there are no ZPMC ultrasonic Inspectors available to confirm this ultrasonic rejection, and he will inform the dayshift QC Inspectors to followup on the ultrasonic indications. This QA Inspector generated and forwarded an Incident Report to Task Leader Mr. Mahlon Lindenmuth. Items observed by this QA Inspector do not appear to fully comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report and the photographs below.



Summary of Conversations:

See 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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
