

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-007050**Date Inspected:** 02-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:** Sun Wei / Sun Bo**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 Components**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Heavy Equipment Shop Bay 10:

The QA Inspector performed a Final 10% random Magnetic Particle Testing (MT) Verification of the Lift 1 North Tower Skin Plates D Bearing Plate welds Weld Joint (WJ) Numbers NSD1-22B/E-10, 13, 16, 18, 22, 25, 26, 38 42 and 43 per ZPMC Notification Sheet 002108 of 02-28-09. There appeared to be no indications and the QA Inspector accepted the above listed welds. The QAA Inspector signed the Green Tag Documentation after ZPMC Representative Zhang Huang and ABF Representative Xiao Jun Peng attached their respective signatures. The QA Inspector observed ABF Representative Xiao Jun Peng attach Green Tag Number 2577.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed 4 ZPMC helpers utilizing angle grinders to clean out excavations from previous Carbon Air Arc Gouging (CAAG) operations on Lift 1 West Skin Plate C.

The QA Inspector randomly observed welding personnel utilizing the CAAG Process to rough shape the copes in the longitudinal stiffeners on Lift 2 West Skin D.

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OBG Sub-Assembly Bay 12:

The QA Inspector performed an initial 100% VT “In Process” Inspection of WJ’s 001 through 008 on Deck Plate 7AW-DP114-002. The QA Inspector marked up areas to be reworked and signed the bottom of “In Process” Yellow Tag with Lot Number B216 on 7AW-DP114-001.

The QA Inspector performed a 100% VT Inspection and a random 10% MT Verification of WJ’s 031 through 062 on the U-Rib Extensions for Deck Plate 1AE-DP585-001. The QA Inspector marked up several areas for re-work. ZPMC Quality Control directed ZPMC welding personnel to perform the re-work. The QA Inspector re-inspected the re-worked areas. There appeared to be no indications and the QA Inspector accepted the above listed welds on Deck Plate 1AE-DP585-001.

The QA Inspector performed a 100% VT Inspection and a random 10% MT Verification of WJ’s 031 through 062 on the U-Rib Extensions for Deck Plate 1AE-DP585-002. The QA Inspector marked up several areas for re-work. ZPMC Quality Control directed ZPMC welding personnel to perform the re-work. The QA Inspector re-inspected the re-worked areas. There appeared to be no indications and the QA Inspector accepted the above listed welds on Deck Plate 1AE-DP585-002.

The QA Inspector randomly observed 5 ZPMC helpers utilizing angle grinders to excavate the U-Rib WJ’s 001 through 010 on Deck Plate 7AW-DP195-001, to remove rejects from previous Ultrasonic Testing (UT) Examination.

The QA Inspector randomly observed 1 ZPMC helper utilizing an angle grinder to excavate the U-Rib WJ’s 002 and 003 on Deck Plate 7BW-DP262-001, to remove rejects from previous UT Examination.

The QA Inspector randomly observed 1 ZPMC helper utilizing an angle grinder to blend the U-Rib WJ’s 001 through 010 on Deck Plate 7BW-DP169-001, after weld repairs.

The QA Inspector randomly observed 1 ZPMC helper utilizing an angle grinder to excavate the U-Rib WJ 001 on Deck Plate 7BW-DP250-001, to remove rejects from previous UT Examination.

The QA Inspector performed a Final 100% VT “In Process” Inspection of WJ’s 001 through 010 on Deck Plate 7BW-DP196-001. There appeared to be no indications and the QA Inspector accepted the above listed welds and signed the applicable box of ZPMC “In Process” Yellow Tag 004009 with Lot Number B216.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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