

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-007069**Date Inspected:** 04-Jun-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 Bay 13)

Segment 7AE

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 splice welds. The Weld Designations are as follows:

SEG034*-001~010.

Segment Repair Yard (North of the blast shop)

Segment 6AE

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:

CA026-037~042, 073~078 and 101~106.

CSD3-PP37-001~012, 025, 026, 041 and 042.

CSD2-PP37.5-007~014.

CSD2-PP38.5-007~014.

CSD2-PP39.5-007~014.

CSD2-PP40.5-007~014.

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CSD3-PP40-063~074, 087, 088, 108 and 109.

CSD9-PP39-001~012, 025, 026, 041 and 042.

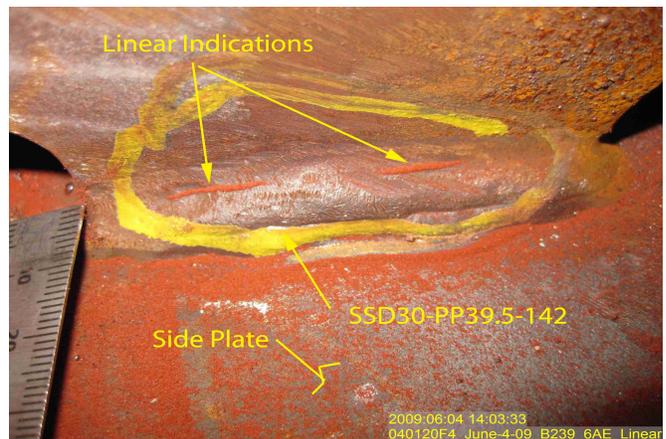
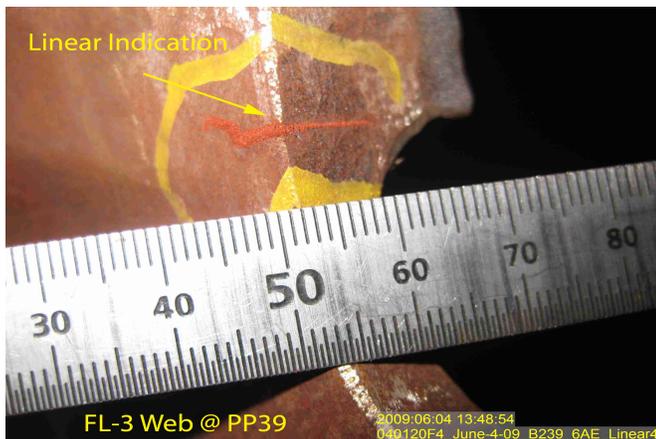
This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the longitudinal girder in way of the cross beam. The Weld Designations are as follows: SEG028M-017, 019, 021 and 022.

During random verification Magnetic Particle Testing of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of (5) five, linear indications from 10mm to 40mm in length in the following welds; SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control MT Technicians. See Incident report on this date.

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.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer