

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-007071**Date Inspected:** 01-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 the 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 bottom and side panel splice welds. The Weld Designations are as follows:
SEG034A-001~010.

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 diaphragm splice welds. The Weld Designations are as follows:
SEG034*-019~026

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 longitudinal diaphragm welds. The Weld Designations are as follows:
SEG034B-001, 002 and 011.
SEG034C-003, 004 and 017.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 super assembly welds. The Weld Designations are as follows:
SSD19-PP48-002, 003, 008, 009, 131, 132 and 138.
SSD19A-PP48-002, 003, 006, 007, 127, 128 and 134.
CSD7-PP48-021~024.

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 splice welds. The Weld Designations are as follows:
CA033-003 and 004.
CA034-003 and 004.

During random verification Ultrasonic testing (UT) of the deck panel diaphragm splice welds, Caltrans Quality Assurance (QA) Inspector visually discovered a total of one (1) transverse linear indications in the deck panel diaphragm to floor beam flange fillet weld identified as weld# SSD19A-PP48-003. This indication was a total of 10mm in length. The ZPMC Quality assurance representative Mr. Wang Lu was then verbally notified and ZPMC technicians then confirmed this indication by Magnetic Particle Testing. This weld, prior to this date, was not yet tested by ZPMC (QC) personnel.

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
