

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007915**Date Inspected:** 12-Jul-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:** Zhoa Chen Sun**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 segment 9DE and North tower lift 1**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Bay 14

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003668 to perform Ultrasonic Testing (UT) of approximately 10% of welds SEG056A-006, 008, 012, 013 and 014 which were previously tested and accepted by ZPMC Quality Control (QC) personnel. The notification was received at 19:45 hrs. This QA arrived in this bay at approximately 20:15 and was unable to locate the welds identified above. This QA contacted ZPMC QA identified as Mr. Ken Zhang for assistance in locating these welds. Mr. Zhang sent ZPMC QC inspector identified as Mr. Guo Xing Hui to bay 14 to assist this QA. QA and QC were still unable to locate these welds. This QA departed this bay at approximately 21:30. No UT was performed on the above mentioned welds.

Tower bay 10

This QA received ZPMC Non Destructive Testing (NDT) notification No. 003668 and assisted Caltrans QA inspector Mr. Dilip Chakrabarti perform Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. Due to the thickness of the welds tested, multiple angle transducers were required. This QA performed the testing with a 45 deg. Transducer while Mr. Chakrabarti

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performed the testing using a 70 deg. Transducer. This QA filled out a UT report for the 45 deg. test for this date. The weld designations are as follows: NSD1-A166E/J-32A/B and NSD1-A112B/H-3A/B.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

As mentioned 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 (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
