

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-008769**Date Inspected:** 31-Aug-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:	N/A	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:	TOWER Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE YARD**Magnetic Particle Testing**

This QA inspector performed random verification MT of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The component details are as follows:

East shaft (Lift-2)

Fit lugs to stiffeners / diaphragm / skin

West shaft (Lift-1)

Fit lugs to stiffeners / diaphragm / skin

This QA Inspector observed the following work not in compliance:

During random verification Magnetic Particle Testing (MT) for the East shaft (Lift-2) and West shafts (Lift-1) fit lugs to stiffeners / diaphragm / skin, observed a total fifteen (15) Transverse and two (2) longitudinal linear indications. These areas were previously tested and accepted by ZPMC MT personnel.

The affected weld designations are as follows:

WELDING INSPECTION REPORT

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East Tower Lift – 2

ESD1-TL7C/L-23 (Diaphragm 53M) Two(2) Transverse linear indications
ESD1-TL7C/L-33 (Diaphragm 53M) One(1) Transverse linear indication
ESD1-TL7C/L-121 (Diaphragm 53M) Two (2) Transverse linear indication
ESD1-TL7C/L-132 (Diaphragm 53M) One (1) Transverse linear indication
ESD1-TL7C/L-208 (Diaphragm 53M) One (1) Transverse linear indication
ESD1-SA300D/F-17A/B(Diaphragm 53M)One (1) Transverse linear indication
ESD1-SA388 (Diaphragm 53M) One (1) Transverse linear indication
ESD1-TL7C/L-136 (Diaphragm 53M) One (1) Longitudinal linear indication
ESD1-TL7C/L-141 (Diaphragm 53M) One (1) Transverse linear indication

West Tower Lift – 1

WSD1-A115A/J-58 (Diaphragm 47.6M) One (1) Transverse linear indication
WSD1-A115A/J-65 (Diaphragm 47.6M) One (1) Transverse linear indication
WSD1-A115A/J-67 (Diaphragm 47.6M) One (1) Transverse linear indication
WSD1-A115A/J-72 (Diaphragm 47.6M) One (1) Transverse linear indication
WSD1-A115A/J-59 (Diaphragm 47.6M) One (1) Transverse linear indication
WSD1-A115H/J-220 (Diaphragm 43M) One (1) Transverse linear indication

For Further details please see the incident report: - 040120F4_TL-15_B227_08-31-09_ (MT) Indications (E2 & W1).

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:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
