

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-008949**Date Inspected:** 01-Sep-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 Jia	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	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz 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 Assembly Yard

This QA Inspector and QA Inspector Mr. Sandeep Kumar performed random MT in the West Tower Lift 1 Shear Lugs to Diaphragm 9M and 13M previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed several rejectable longitudinal indications and porosity at the time of testing. The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below:

North Tower Lift 1

Skin B Diaphragm 9M

1. NSD1-SA11A/H-72 (1 longitudinal indication)

Skin E Diaphragm 13M

1. NSD1-SA76B/H-172 (1 longitudinal indication)

Skin D Diaphragm 13M

1. NSD1-SA22B/H-107 (2ea) (1 area had porosity with a longitudinal indication and 1 had porosity)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed longitudinal indications in the above noted welds accepted by ZPMC QC MT personal.

This QA Inspector issued an incident report on the above noted MT rejections.

This QA Inspector and QA Inspector Mr. Sandeep Kumar performed random MT in the West Tower Lift 1 Shear Lugs to Diaphragm 9M and 13M previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed several rejectable transverse indications at the time of testing. The QA Inspector generated a TL-6028 MT report on this date. Weld MT verified was identified as listed below:

North Tower Lift 1

Skin B Diaphragm 9M

1. NSD1-SA112A/H-48, 46, 43

Skin C Diaphragm 9M

2. NSD1-SA17A/H-2

Skin D Diaphragm 9M

3. NSD1-SA22A/H-107

Skin D Diaphragm 9M

4. NSD1-SA76A/H-85

Skin A Diaphragm 13M

1. NSD1-SA33B/H-182

Skin B Diaphragm 13M

1. NSD1-SA11B/H-161

This QA Inspector observed longitudinal indications in the above noted welds accepted by ZPMC QC MT personal.

This QA Inspector issued an incident report on the above noted MT rejections.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 (134-8257-0045), who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------