

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-009521**Date Inspected:** 13-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	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 Subassemblies	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector performed a fabrication survey for Bill of Materials, Fit-up and Welding Details on BP3011 utilizing the following drawings, details and supplementary information:

BP3011 Dated 04/13/09

BP3011A Dated 04/13/09

RS3018 Dated 07/10/09

RS3021 Dated 04/18/09

SD508 Dated 03/13/09

X3029 Dated 04/17/09

WD12 Dated 07/27/09

WD13 Dated 06/18/09

WD14 Dated 07/27/09

WD17 Dated 07/24/09

WD18 Dated 04/20/09

OBG WD18 Weld Detail NDT Requirements (Sub0087R42 Dated 06/10/09)

GN1 thru GN5, RFI-CAN 0544R01 and ABF-RFI-0825R01

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This QA Inspector conferred with SMR and SMR responsible for OBG components relative to dimensional tolerance requirements and noted camber required for the specific member inspected.

This QA Inspector reviewed and revised UT procedure for the detection of suspected transverse planar discontinuities with significant flaw height dimension to include clarification on UT techniques and evaluation of flaws detected in the second leg of sound.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
