

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010010**Date Inspected:** 06-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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. QA Inspector observed and/or found the following:

OBG Assembly Yard

2AE-2BE

QA Verification UT performed on portion of Deck plate to Edge plate weld of 2AE and 2 BE (Bike Path side). This Inspection was performed after ABF UT Inspectors performed 100% UT of this joint. UT performed utilizing scanning pattern D.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 6th, 2009 for further information on inspection.

ABF Inspection Request No. 11062009-1

This QA Inspector witnessed ABF Inspectors performing VT and UT of OBE1A-009, 010 (1AE to 1BE transverse seam SP, BK side)

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This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBE1A-009, 010 utilizing scanning pattern A, B, C and D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 6th, 2009 for further information on inspection.

ABF Inspection Request No. 11062009-2

This QA Inspector witnessed ABF Inspectors performing VT and UT of OBW1-001 (1AAW to 1AW transverse seam DP)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBW1-001 utilizing scanning pattern A, B, C and D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 6th, 2009 for further information on inspection.

ABF Inspection Request No. 11062009-4

This QA Inspector witnessed ABF Inspectors performing VT and UT of OBE1A-001, 002 (1AAE to 1AE transverse seam SP, CB side)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBE1A-001, 002 utilizing scanning pattern A, B, C and D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 6th, 2009 for further information on inspection.

ABF Inspection Request No. 11062009-3

This QA Inspector witnessed ABF Inspectors performing VT and UT of OBE1A-004, 005 (1AAE to 1AE transverse seam SP. BK side)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBE1A-004, 005 utilizing scanning pattern A, B, C and D (Fig 6.7)

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See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 6th, 2009 for further information on inspection.

Inspection of 1AE to 1 BE transverse seam OBE1A, 006,007 (SP, CB side), OBE1A-008 (BP) and 1AAE to 1AE transverse seam OBE1-001, 009, 010 did not start when this QA Inspector was present. A turnover was done to QA Inspector Shrikant Utekar for the same.

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:	Dsouza,Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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