

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-010470
Date Inspected: 29-Nov-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:	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:	OBG	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar 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:

HEAVY DOCK

ULTRASONIC INSPECTION

OBG SEGMENT 4 EAST

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

Ultrasonic Testing (UT) performed on repair areas of the corner weld between edge panel and deck panel (cross beam side) of OBG segment 4 East (CA010-002, 004, 006, SEG020*-035, 037) utilizing scanning pattern A, B, C and D (Fig 6.7).

TRIAL ASSEMBLY YARD

OBG SEGMENT 2 WEST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the corner weld between edge panel and deck panel (cross beam side) of OBG segment 2 West (CA102-002, 004, 006, SEG007A-029, 045) utilizing scanning pattern A, B, C and D (Fig 6.7). During the ultrasonic inspection this Quality Assurance (QA) Inspector found 2 transverse linear indications that had not identified by ABF.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated 11/29/2009 for further information on inspections.

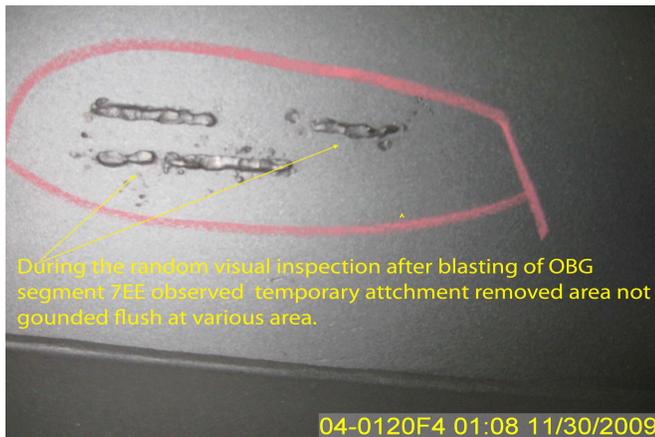
BLASTING SHOP

VISUAL INSPECTION

OBG SEGMENT 7EE

This Quality Assurance (QA) Inspector performed random visual inspection after blasting along with Caltrans Quality Assurance (QA) Inspector Mr. Paul Dawson on inside upper panel, floor beam and inside corner assembly diaphragm of OBG segment 7DE. During the inspection we found normal minor gouges, arc strikes, spatter, undercut like discontinuities. For additional information see attached photos.

Unless otherwise noted, all work observed on this dated 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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer