

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-010707**Date Inspected:** 27-Nov-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:	NA	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 date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

South of Blast Bay-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 7EE deck panel Complete Joint Penetration (CJP) weld SEG042*-006 after heat straightening. See MT report TL-6028 generated on this date for further detail.

During Visual inspection prior to Magnetic Particle Testing (MT) as per NDT inspection notification sheet # 004740, this Caltrans Quality Assurance (QA) Inspector observed that base metal distortion repairs have been performed on deck panel DP469A. The repair areas were adjacent to deck panel Complete Joint Penetration (CJP) weld SEG042*-006 joining DP442A and DP469A. This base material distortion repair was performed without the approval of the Engineer. An Incident report was issued for the above mentioned anomaly.

The Y location, length and width of repair are as follows:

#1 at 'Y' location 6000 mm, approximately 350 mm long and 100 mm wide

#2 at 'Y' location 7180 mm, approximately 350 mm long and 100 mm wide

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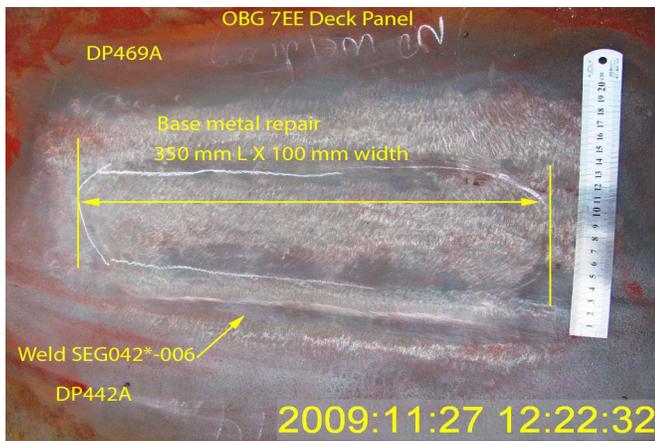
OBG Trial Assembly and Heavy Dock-

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 North Tower Lift 3 Skin Plate A to E corner joint weld, NSTL3-3 B/K- 84B utilizing scanning pattern D (Fig 6.7)

No transverse indications were found on this date during UT verification of NSTL3-3-83B.

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



Summary of Conversations:

As identified within the contents of this report.

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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
