

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-011239**Date Inspected:** 21-Jul-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:	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 Deck Panels	

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.

QA Inspector performed QA Verification conventional Ultrasonic Testing (UT) to the requirements of AWS D1.5:2002 on OBG Deck Panel Splice Plates. Welds tested and results are as follows:

USPL1-141 Welds 001, 002;
 USPL1-142 Welds 001, 002;
 USPL1-143 Welds 001, 002;
 USPL1-144 Welds 001, 002;
 USPL1-145 Welds 001, 002;
 USPL1-146 Welds 001, 002;
 USPL1-147 Welds 001, 002;
 USPL1-148 Welds 001, 002;
 USPL1-149 Welds 001, 002;
 USPL1-151 Welds 001, 002;
 USPL1-152 Welds 001, 002;
 USPL1-153 Welds 001, 002;
 USPL1-154 Welds 001, 002;
 USPL1-155 Welds 001, 002;

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

USPL1-156 Welds 001, 002;
USPL1-157 Welds 001, 002;
USPL1-158 Welds 001, 002;
USPL1-160 Welds 001, 002;
USPL1-107 Welds 001, 002;
USPL1-095 Welds 001, 002;
USPL1-120 Welds 001, 002;
USPL1-127 Welds 001, 002;

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP264-001: Visual Inspection repairs incomplete and in-process: Deck Panel not ready.
DP451-001: Final VT appears to comply with code and contract requirements.

QA Inspector performed QA Verification Magnetic Particle Testing (MT) on U-rib deck panel assemblies following the guidelines of Caltrop MT Procedure CTMT-08-00 Rev. 2.1. Deck Panels Inspected and results are as follows:

DP451-001: 15% MT-Tested.
DP264-001: 15% MT-Tested.

QA Inspector performed Green Tagging activities following the green tagging procedure. The deck panels green tagged are as follows:

DP451-001: Green Tag Number 9734

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
