

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-011745**Date Inspected:** 18-Jan-2010**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 Assembly	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Trial Assembly

5BW-5CW Splice

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the T and I rib splice welds for segment splice 5BW to 5CW. The Weld Designations are as follows:

DP621-001-024

DP627-001-024

EP038-001-014

EP046-001-013

SP410-001-032, 033.

SP092-001-031

SP119-001-026

SP749-002-058

SP471-002-069

SP418-002-032, 033

SP092-001-031

BP030-001-030

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BP138-001-022, 024

5BE-5CE Splice

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the T and I rib splice welds for segment splice 5BW to 5CW. The Weld Designations are as follows:

DP630-001-023

DP633-001-023

EP050-001-014

EP052-001-013, 014

SP418-001-032, 034

SP523-001-064, 065

SP359-001-028

SP305-001-023

SP424-001-032, 035

BP057-001-025

BP111-001-025

During random verification Ultrasonic Testing (UT) of the Edge Panel Open Rib Stiffener splice welds, Caltrans Quality Assurance (QA) Inspector discovered a total of (2) two, rejectable defects of up to 30mm in length. The weld designations are as follows; EP052-001-014 and EP046-001-013. These welds have been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

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: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer