

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-014198**Date Inspected:** 03-Mar-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:** Xu Xian Ping**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 Sub-Assembly**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.

Non-Destructive Testing (NDT):

Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005260):

Visual Testing:

This QA inspector performed Visual Testing (VT) of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Miscellaneous OBG Components. The weld designations reviewed are as follows:

M202G Catwalk Railing (3 Assemblies)

This QA Inspector performed a survey of on-going work in progress in the Sub-Assembly Bays with the following results:

BAY 1

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03-03-10

CB15 – Welding approx. 45% complete

Assembly has not been turned yet

No NDT Performed.

Traveler Brackets – 13TB1 Welding Complete

134 Welded only / 70 Welded and Ground / No NDT Performed

Traveler Rails – 20TR1

8 rails fit-up only / 20 half welded / 32 weld complete

No HSR Performed / No NDT Performed

BAY 2

Traveler Rails – 11TR1

29 rails w/repairs in process

UT Repairs 80% complete / Edge Buttering 40% complete

No HSR Performed

BAY 3

Corner Assemblies - CA6501, CA3001~CA3007, SEG072, SEG067, SEG068

39 Assemblies welding complete / No NDT Performed

Traveler Rails – 20TR2

20 rails welding complete / VT pickup in process

No HSR Performed / No NDT Performed

BAY 4

No Activity on our job.

Bay 5

Traveler Rails – 11TR2

36 rails NDT Complete / 27 rails repairs pending / 22 rails repairs in process

BAY 6

CB9 95% complete

ZPMC UT, ABF UT complete – OK

ZPMC MT-OK, ABF MT – Rejects

U-rib Conn. Plates – USPL1

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8 units fit only / 36 units half welded / 3 units welding complete / 11 units ZPMC UT-OK

West Jacking Frame

120 plates CTS / 30 plates Layout in process

Railings

90 rails welding complete / 30 rails fit only

Grinding pending / No VT Performed

BAY 7

Traveler Rails – 22TR3 and 22TR4

11 rails welding complete

No HSR Performed / No NDT Performed

Traveler Rails – 10TR1 and 11TR1

27 rails HSR in process / No NDT Performed

BAY 8

CB17 – Erection pending

Bottom Plate Sub-assembly splices 50% welded / Side and Top Sub-assembly splices pending

No NDT Performed

Traveler Rails – 10TR1

14 rails UT repairs in process

No HSR Performed

Floor Beam (corner assemblies)

14 assemblies half welded / 10 assemblies welding complete

No NDT Performed

BAY 9

Deck Panels

1 Lift 12 Deck Panel (DP3006-001) with 1 MT reject CWR Pending / PAUT Complete

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Holmes,Stefan	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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