

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-015337**Date Inspected:** 02-Jul-2010**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

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|------------------------------------|---------------------------------|----------------------------------|--------------------------|----------------------|
| 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: | Tower and OBG Components | |

Summary of Items Observed:

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

Bay 10

This QA Inspector randomly observed no welding related work in progress in Bay 10.

Bay 11

This QA Inspector randomly observed no welding related work being performed in Bay 11.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

Air arc removal of temporary plate previously welded to PCMK 9BW, panel points 74~76, deck at FL3 extension.

ZPMC personnel placing U-rib bolt sets at 8AW/8BW, panel points 64~65, transverse deck joint.

Match drilling at 8BW, side plate north (counterweight) side stiffeners. Drilled through previously drilled holes in retrofit connection T-joint assemblies into side plate T-stiffener webs.

Heavy Dock

This QA Inspector randomly observed the following work being performed on the Heavy Dock:

WELDING INSPECTION REPORT

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This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 were erect with all 4 tower lifts 3 attached above, respectively. Crossbeam 7 and crossbeam 8 were sitting on stanchions on the foot of the dock. No ZPMC floating crane was in the immediate area. The worker access tower elevator was unmanned and dark.

OBG Trial Assembly Area - MT

In response to ZPMC Inspection Notification #006107, item 1, for magnetic particle testing (MT) inspection of retrofit T-joint assembly to side plate welds on the south (crossbeam) side of OBG 8W, this QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members were identified as follows:

OBG 8DW-

RETRO-G-01-8DW-A1. The weld designations reviewed were: 026, 027, 029, 030, 037, 038.

RETRO-G-01-8DW-A2. The weld designations reviewed were: 033~036.

OBG 8EW-

RETRO-G-01-8EW-A3. The weld designations reviewed were: 007, 008, 009, 010, 011, 012.

No relevant indications were observed.

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

Summary of Conversations:

This QA Inspector and QA Inspector Paul Dawson, who was also performing MT of various retrofit T-joint assembly to side plate welds, were informed by ZPMC MT technicians in OBG 8W that other welds were not going to be ready for MT inspection this night.

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.

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| Inspected By: | Goulet,George | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
