

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-015514**Date Inspected:** 09-Jul-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	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 9BE-9CE

ABF Report No: UT-9E-050

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the deck panel splice weld between OBG segment 9BE and 9CE. The weld designations are as follows.

OBE9- 009 (OBG 9BE-9CE- D.P)

OBG SEGMENT 9CE

ABF Report No: UT-9E-056

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT

WELDING INSPECTION REPORT

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Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Cross beam side) of OBG segment 9CE. The weld designations are as follows.

CA063-002 (OBG 9CE-D.P to E.P, C.B side @ 9BE)

OBG SEGMENT 9BE

ABF Report No: UT-9E-055

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Cross beam side) of OBG segment 9BE. The weld designations are as follows.

CA052*-044 (OBG 9BE-D.P to E.P, C.B side @ 9CE)

OBG SEGMENT 9CE

ABF Report No: UT-9E-054

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Bike path side) of OBG segment 9CE. The weld designations are as follows.

CA064-006 (OBG 9CE-D.P to E.P, BK side @ 9BE)

OBG SEGMENT 9BE

ABF Report No: UT-9E-053

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Bike path side) of OBG segment 9BE. The weld designations are as follows.

CA060-002 (OBG 9BE-D.P to E.P, BK side @ 9CE)

OBG SEGMENT 9BE-9CE

ABF Report No: UT-9E-052

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the edge panel splice weld between OBG segment 9BE and 9CE (Cross beam side). The weld designations are as follows.

OBE9-006 (OBG 9BE-9CE-E.P, C.B side)

OBG SEGMENT 9BE-9CE

ABF Report No: UT-9E-051

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the edge panel splice weld between OBG segment 9BE and 9CE (Bike path side). The weld designations are as follows.

OBE9-010 (OBG 9BE-9CE- E.P, BK side)

ULTRASONIC INSPECTION

OBG SEGMENT 9BE-9CE

ZPMC NWIT No: 006160

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 9BE and 9CE. Weld Designations are as follows.

DP680-001-021; EP169-001-013; DP711-001-020; SP707-001-032; SP319-001-059, 061, 055; SP346-001-044; BP125-001-020, 022; BP071-001-022, 024; SP623-002-002~004; SP583-002-006; SP681-002-056; EP145-002-027.

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

Summary of Conversations:

Only general conversation was held between QA and QC

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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
