

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-016099**Date Inspected:** 31-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:** Guo Yen Fei**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:** Bay 1, 4, 9**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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 observed and/or found the following:

Bay 1

CB 15

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 CB15 side plate to bottom plate West. The weld designations are as follows

CB202A - 015 - 001

Bay 9

ZPMC NWIT 06311

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG component previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

DP3171 – 001 – 320, 323, 328, 331

DP3170 – 001 – 290, 293

DP3176 – 001 – 266, 269

This QA Inspector generated a TL-6027 UT report on this date.

Bay 4

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:

DP 3143-001: Final VT appears to comply with code and contract requirements.

DP 3146-001: Final VT appears to comply with code and contract requirements.

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

DP 3143(PL 3339A)-001: Green Tag Number 14224

DP 3143(PL 3339B)-001: Green Tag Number 14225

DP 3143(PL 3339C)-001: Green Tag Number 14226

DP 3146(PL 3342A)-001: Green Tag Number 12837

DP 3146(PL 3342B)-001: Green Tag Number 12838

DP 3146(PL 3342C)-001: Green Tag Number 14223

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.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------