

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-000545**Date Inspected:** 30-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Wen Sheng & Xu Le Feng	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:	77-A & 114-D	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 77 Skin-A Gouged out areas on stiffeners MP2-1 (1 area) and MP2-2 (5 areas) were observed during a Magnetic Particle (MT) Test by Qai Xin Xin and was MT/OK. This Caltrans QA Inspector performed an MT test on areas of the gouges and found them to be in compliance with project specifications. Gouged out areas were later set up for preheating for the repair welding.

Item-2 114 Skin-D Upper Section. Indications found buy the previous Ultrasonic Testing (UT) were in the process of being gouged out. The QC present was Zhao Chensun and Zhang Qiao.

Item-3 114 Skin-D Lower Section. Complete Joint Penetration (CJP) welds are in the process of being backed gouged and ground down to good metal. The QC present was Qu Yan Kun. Welding being performed by Jiang Zhou #040261 and the welding parameters recorded by this QA Inspector were, Amps 310, Volts 30.8, Travel Speed 298 mm/min. and the WPS was WPS-B-T-2232-TC-U5-F.

Item-4 114 Inner Connection Plate Face A. Filler weld metal being added to stiffener P268-1 to plate MUC-A58 by welder Chang Chinkiang #053870. The WPS utilized was WPS-B-T-2232-TC-U5-F and the welding parameters recorded by this QA Inspector were, Amps 295, Volts 30.1 and travel speed was 298 mm/min. The CWI on site was Lu Jianping. Prior to the end of the swing shift progress did stop for the evening and will resume during the morning of Oct.1, 2007, first shift.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
