

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001648**Date Inspected:** 25-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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:** Deck plate u-rib welding**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and the orthotropic box girders, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Deck Plate	NA	NA	welding in progress

OBG Bay 1: OBG -Production Monitoring Test (PMT) #12 for closed rib welding on Deck Plates DP-019-001 and DP-017-001 gas metal arc welding (GMAW) and submerged arc welding (SAW) is being performed with gantry number 2. The GMAW of the production monitoring test is being performed in sequence with the welding of the deck plate DP-019-001. Prior to GMAW of the closed rib partial joint penetration (PJP) groove welds. Caltrans QA observed the surface condition of the surfaces where welding is to be applied. Caltrans QA identified cases of rust within the PJP groove that was brought to the attention of ZPMC and was removed by electrical powered wire wheel brushing. The Caltrans QA identified a GMAW tack weld that has a crack and also observed ZPMC in process of performing a repair of an additional GMAW tack weld. ZPMC removed these GMAW tack welds by grinding and then performed magnetic particle testing (MT) of the GMAW cracked tack weld area. ZPMC reported no discrepancies after MT and rewelded the GMAW tack weld. There was no SAW performed of the PMT or deck plate DP-019-001. There was also no GMAW applied to deck plate DP-017-001 during Caltrans QA Inspector's presence. Visual Test (VT) results of the PJP welds were not completed during Caltrans QA Inspector's presence. The following digital picture illustrates deck panel DP019-001 at gantry #2.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As identified within the contents of this report.

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

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
