

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-001815**Date Inspected:** 21-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****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 Deck Plate**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, Orthotropic Box Girders (OBG) and Tower, 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 OBG Closed U-rib Panel	NA	NA	QA VT

OBG Bay 1: Caltrans QA Inspector performed visual inspection of the completed submerged arc welding (SAW) cover pass welds; partial joint penetration (PJP) welds joining the closed ribs to deck plate panel DP137-001, u-rib U51, welds 1 & 2; u-rib U41, welds 3 & 4; u-rib U46, welds 5 & 6, u-rib U45 welds 7 & 8, u-rib U57 welds 9 & 10 and DP002-001, u-rib U74/25 weld 1, u-rib U149/27 welds 5 & 6 and u-rib U75/31 welds 7 & 8. However DP137-001, weld 3 SAW cover-pass weld was partially welded out. The weld was terminated at the 3050mm mark. DP002-002 weld 1, SAW cover-pass weld was also partially welded out. This weld was terminated at the 3255mm mark. The weld that were completed; Caltrans QA observed welding overlap, over size welds, underfill and incomplete fusion. These indications observed at the weld were marked in yellow paint stick along the distance from the "Y" axis, starting at the weld start too weld completion end. The weld indications observed were recorded on Caltrans spreadsheet for future reference. The following digital picture illustrates u-rib deck plate panel DP137-001.

WELDING INSPECTION REPORT

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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
