

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-003050**Date Inspected:** 03-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Lu**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 Panels**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

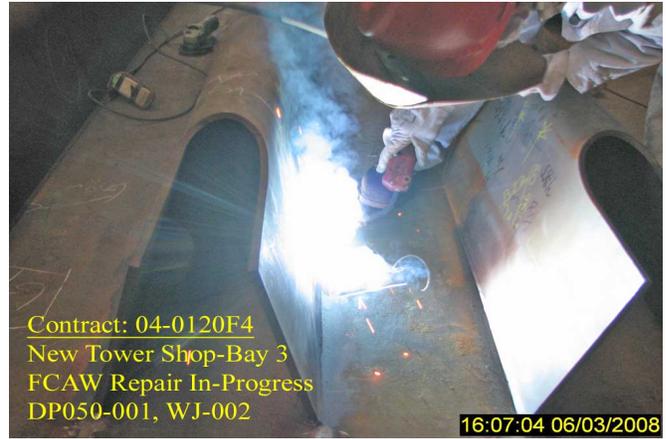
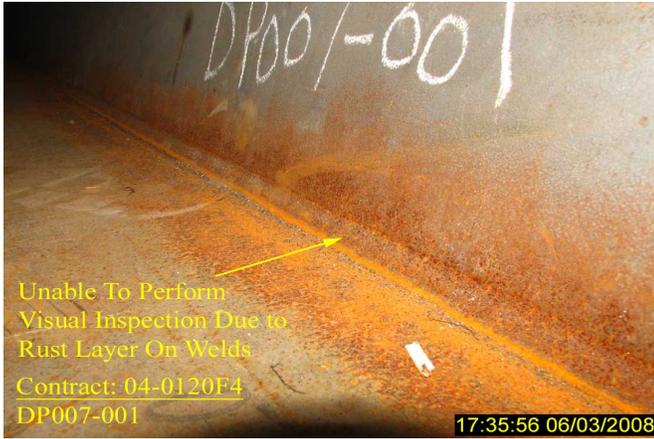
Bay 3--New Tower Building

The QA Inspector randomly observed ZPMC welding and QC personnel performing inspection, in-process grinding and Flux Cored Arc Welding (FCAW) of repairs for deck panel Partial Joint Penetration (PJP) welds. The QA Inspector observed ZPMC personnel performing in process repairs on DP007-001, DP029-001, DP050-001 and DP056-001.

The QA Inspector performed documentation of FCAW repairs for DP050-001, welds 001 through 010. The QA Inspector later completed initial visual inspection for DP029-001 welds 001 through 006. Four deck panels were later transported out of the shop and were identified as DP039-001, DP006-001, DP041-001 and DP040-001. Later in the shift the QA Inspector attempted to perform initial visual inspection on DP007-001, but was not able to perform a proper inspection due to excessive rust and corrosion on the welds.

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Summary of Conversations:

At the beginning of the shift the QA Inspector was informed by first shift QA Inspector William Clifford that DP007-001 and DP029-001 need initial visual inspections.

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:	Leach,Ed	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
