

**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-003074**Date Inspected:** 15-Jun-2008**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:** Huang Wen-Pang**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:** Tower / OBG**Summary of Items Observed:**

Bay 3 Deck repairs

The QA Inspector randomly observed ZPMC welding and QC personnel performing grinding of repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-five (35ea) deck panels are inside the shop. This QA inspector performed 10% Magnetic Particle (MT) on deck panel DP006-001, repair work in-process on deck panels DP078-001 and DP027-001 by ZPMC.

## Bay 7 Cracked tack weld

This QA inspector observed ZPMC in bay 7 performing tack weld repairs on component number FB028-002-117 due to cracked tack weld, ZPMC notified Caltrans QA prior to the removal of the crack and the location was verified by this QA inspector for excavation. ZPMC did perform Magnetic Particle inspection to ensure soundness and removal of the crack for this location. Also noted in this bay was in process weld repairs due to porosity in the fillet welds for flange plate to web plate connections. ZPMC had removed these locations using the air carbon arc gouging process and was in the process of grinding these locations prior to resuming the welding process. The following is a list of locations and number of areas repaired for each weld joint; FB011-008-009 4 repair areas, FB011-008-003 15 repair areas, FB016-008-003 15 repair locations and FB016-008-046 4 repair locations. It was noted that ZPMC's CWI Huang Wen-Pang was present during the welding repair operations in this bay and monitoring welding parameters and in process progression. Also present to assist Mr. Wen-Pang was ZPMC QC personnel for monitoring.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As Noted Above.

## 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.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
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