

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-003082**Date Inspected:** 08-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sai Fa**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**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, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-one (37ea) deck panels are inside the shop. The deck panels in repair process are designated as: DP028-001, DP029-001 & DP032-001.

Magnetic Particle Testing

The QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the QC final MT completed deck panel repairs on deck panel designation DP003-001. This QA Inspector generated a TL-6028 MT report on this date. The weld designations where the MT was performed on both deck panels is 001 through 010, from approximately 14,000 mm Y to 16,355 mm Y. No apparent relevant indications were noted.

OBG-Bay 1

The QA Inspector witnessed ZPMC personnel Wang Wei perform MT for 100% of the tack welds prior to welding of deck panel PMT-601-001 & 551-001. After ZPMC completed the inspection, the QA Inspector also performed MT for a portion of the tack welded areas. No apparent relevant indications were noted.

Later in the shift, once the welding of the PMT was completed, the QA Inspector assisted QA Inspector Steve Hall

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with visual inspection and laying out the macro test samples. The QA Inspector also witnessed ZPMC complete UT evaluation for LOP on the PJP welds. Upon completion of testing ZPMC accepted the evaluation. On this date, the QA Inspector made a random observation to each bay to collect general information to complete the swing shift tie-in and personnel tracking log for this date. This information was later compiled and sent by e-mail to applicable Caltrans personnel.



Summary of Conversations:

The QA Inspector was informed by dayshift QA task leader Jim Cochran that ZPMC intends to weld a deck panel PJP production monitoring test (PMT) at 0001hrs on this date. Mr. Cochran stated that the PMT will consist of ZPMC evaluation by MT of the tack welds prior to welding and 100% ultrasonic testing (UT) by ZPMC for lack of penetration (LOP) of the PJP welds after welding.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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