

**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-003116**Date Inspected:** 11-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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 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 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, 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-seven (37ea) deck panels are inside the shop. The deck panels in repair process are designated as: DP027-001, DP030-001, DP032-001 & DP006-001. The QA Inspector spent a portion of the shift monitoring and documenting the repaired locations on DP027-001. The work in progress appeared to be in general compliance with the contract specifications.

**Visual Testing (VT)**

The QA Inspector performed initial VT, along with ABF and ZPMC QC personnel on deck panel DP006-001 prior to the initiation of welding repairs. Once the inspection was completed and a mutual agreement was reached for each marked area, a representative for each party signed and dated the yellow in process repair tracking sticker. Repair work for this deck panel was initiated as of 1530hrs.

**Magnetic Particle Testing (MT)**

The QA Inspector performed final MT for approximately 15% of the repaired areas on DP043-001. This

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

inspection covered the repaired areas for the length of weld joint designation 001. The final VT and MT were completed on first shift by ZPMC QC, ABF QC and Caltrans QA personnel William Clifford. A TL-6028 MT report was generated on this date.

**Summary of Conversations:**

No relevant conversations this date.

**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.

---

<b>Inspected By:</b>	Leach,Ed	Quality Assurance Inspector
----------------------	----------	-----------------------------

---

<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------