

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-003187**Date Inspected:** 23-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Jiang Jian Fei	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:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 2:

The QA Inspector randomly observed ZPMC welder Xue Yian ID Number 040364, utilizing the Submerged Arc Welding (SAW) Process in the 1G Position (Flat Groove) with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2221-B-U3c-S to weld the fill pass in WJ ESD1-SA216A/K-19A/20A on Tower Skin Plate E Sub-Assembly SA216(E). The QA Inspector randomly observed ZPMC CWI Jiang Jian Fei monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 652 amps, 33.2 volts with a travel speed of 610 millimeters (mm) per minute. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

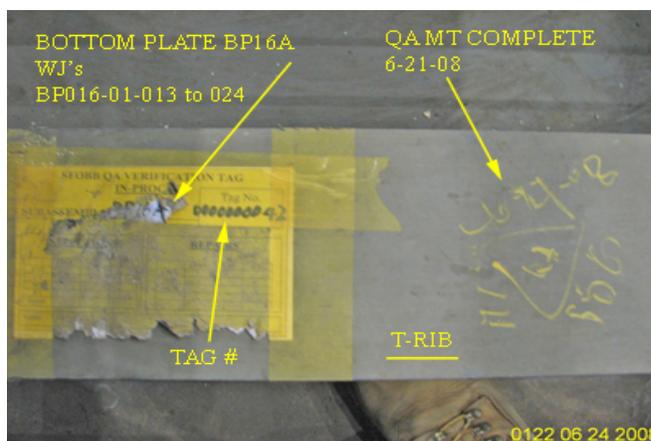
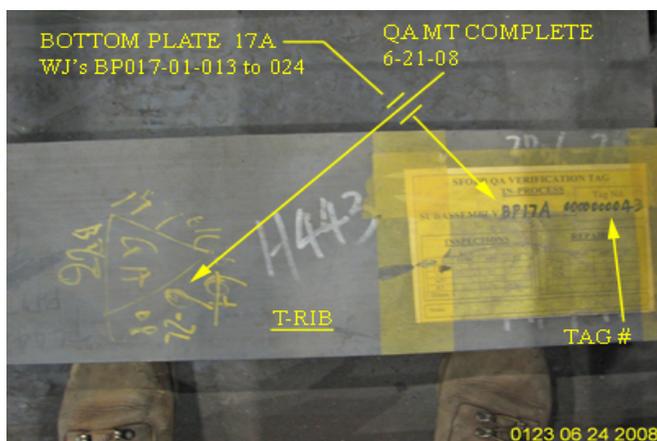
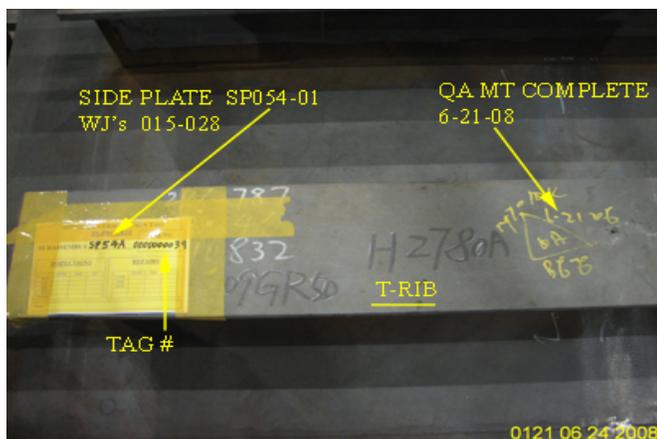
OBG Bay 1:

The QA Inspector performed a random 10% Magnetic Particle Testing (MT) verification of the fillet welds attaching the U-Ribs to Bottom Plate BP18A WJ's BP018-01-013 through 024. There appeared to be no indications. See corresponding 6028 for 06-23-08.

The QA Inspector verified that QA had performed final MT verification on Side Plates SP23A, SP31A, SP54A, SP66A, SP78A and Bottom Plates 16A and 17A. The attached photographs provide additional detail.

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Summary of Conversations:

There were no relevant conversations.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer