

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-003534**Date Inspected:** 29-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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/T0wer**Summary of Items Observed:**

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

OBG –Outside Repair Area

The QA Inspector observed ZPMC personnel performing general grinding on various deck panel repair welds.

Bay 1 – OBG Shop

The QA Inspector observed Mr. Wang Wei of ZPMC performing Magnetic Particle Testing (MT) of tack welds on deck panel DP583-001 and DP593 after grinding at Gantry # 2.

Mr. Wei informed the QA Inspector that two indications were found on DP593-001 during the MT testing.

The QA Inspector observed ZPMC personnel removed cracks with further grinding.

The QA Inspector observed tack weld grinding on deck panel DP588-001 had been completed was idle at Gantry #2 (SAW) welding was completed, DP588-001.

The QA Inspector also observed various work being performed by ZPMC personnel on deck panel sections such as drilling of holes in u-ribs, grinding of paint from plate material at areas where u-ribs are to be welded.

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The QA Inspector observed the Flux Cored Arc welding in progress of U-rib stiffeners by ZPMC qualified and approved welder Dong Yi Qun ID 059450 to be used on DP558-001.

The welding in progress appeared to comply with the WPS-B-T-2133 and the contract requirements.

For more detail see photographs shown below:



Summary of Conversations:

As noted within the report shown 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 Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Dixon, Roscoe

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer