

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-003605**Date Inspected:** 25-Jul-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:	Chen Xi and Yu Dong 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:	deck panels and side plates	

Summary of Items Observed:

Heavy Duty Machine Shop – Bay 3:

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final MT (10% verification) on DP042-002-001 through 008. No apparent indications.

ZPMC personnel were grinding on panels DP496-001 and DP353-001. Fourteen ZPMC workers were present in this shop as well as ABF QC Kevin Chen and ZPMC CWI Chen Xi. Twenty-seven deck panels were in the bay. No welding was observed being performed.

Sub-Assembly – Bay 4:

QA Inspector was present in Bay 4 in response to an inspection request for final MT of SP387-001-001 though 012. QA Inspector observed this panel in a stack with two panels over it. ABF QC Louis Liu was also present and informed QA Inspector that nothing could be done to make the above noted panel accessible.

QA Inspector observed ZPMC CWI Yu Dong Pang monitoring the welding on tower diaphragm assemblies. Other work being performed was grinding and heat straightening on diaphragms. Approximately 60 ZPMC workers were present in this bay.

Heavy Duty Machine Shop – Bay 3:

QA Inspector later returned to this bay and performed final VT on DP108-001, DP299-001, DP326-002, and DP432-001 with ABF QC Kevin Chen and ZPMC CWI Chen Xi. All welds appeared to be in compliance with contract documents, in concurrence with the noted QC and CWI.

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 Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
