

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-003742**Date Inspected:** 29-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xian Jun Peng and CK Chen			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:

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing Island, China for the purpose of observing and monitoring the fabrication of the Tower and OBG.

Bay 1

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener P240.

The Quality Assurance Inspector observed ZPMC performing grinding and air carbon arc operations on various longitudinal stiffeners weld runoff tabs.

The Quality Assurance Inspector observed ZPMC utilizing chalk layout lines in an effort to aid in the fit up on longitudinal stiffener to skin plate B South Tower Assembly.

The Quality Assurance Inspector observed ZPMC personnel in process of performing fit operations on longitudinal stiffener plates to skin plate E South Tower Assembly.

Skin Plate A South Tower Assembly

American Bridge/Fluor Representative Jean Rosamilia informed the Quality Assurance Inspector, ZPMC personnel ZPMC is in process repairing by grinding visual indication such as porosity and slag in the filler pass prior to continuing on welding the weld joining the longitudinal stiffener to skin plate.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Longitudinal Stiffener

The Quality Assurance Inspector observed ZPMC Caltrans approved welder 053869, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number SSDI-SA-178 A/D 6A. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

Bay 2

The Quality Assurance Inspector observed ZPMC Ultrasonic Technicians perform ultrasonic testing on various longitudinal stiffeners.

Skin Plate A East Tower Assembly

The Quality Assurance Inspector informed American Bridge/Flour Representative CK Chen, ZPMC was observed by the Quality Assurance Inspector to be welding the FCAW over areas of rust in the bevel joining the longitudinal stiffeners to skin plate A East Tower Assembly. American Bridge/Flour Representative CK Chen informed the Quality Assurance Inspector, ZPMC will remove the rust and an Incident Report will be issued to ZPMC.

Bay 3

The Quality Assurance Inspector observed ZPMC grinding and performing flux core arc welding (FCAW) on visual weld repairs on Orthotropic Box Girders (OBG) DP 351-001, DP218-001, DP326-001, DP459-001, DP-216-001, and DP135-001.

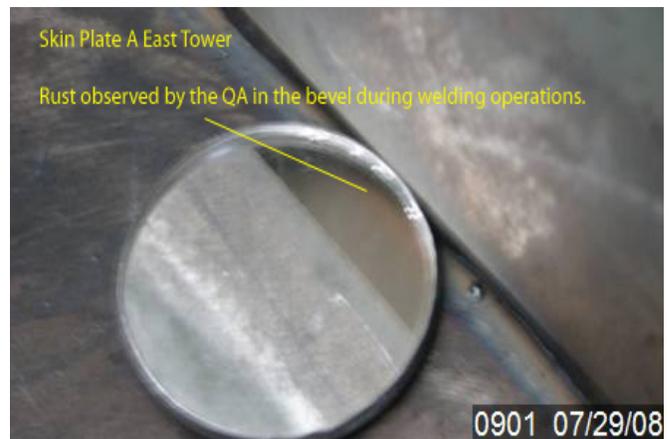
The Quality Assurance Inspector performed a random initial visual observation on Orthotropic Box Girders (OBG) DP-218-001 and DP-434-001. The Quality Assurance Inspector observed several areas of under fill and undercut. ZPMC and American Bridge/Flour Quality Control Inspector agreed with the visual observations found by the Quality Assurance Inspector. ZMPC Quality Control Inspector informed the Quality Assurance Inspector, he will contact the Quality Assurance Inspector when the repairs are complete.

Magnetic Particle Test

The Quality Assurance Inspector performed 10% random magnetic particle testing verification on Deck Panels. The Quality Assurance Inspector performed the testing on the following Deck Panels; DP-486-001, DP-299-001, DP-405-001, and DP353-001. See Caltrans report TL-6028 Magnetic Particle Test Report, dated July 29, 2008 for additional information.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)



Summary of Conversations:

No relevant conversations on 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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Lara, Raymond	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Lanz, Joe	QA Reviewer
---------------------	-----------	-------------