

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-003579**Date Inspected:** 06-Aug-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:	Li Yan Hua/ Yu Dong Ping	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).

Bay 3 – Heavy Duty Machinery Shop

The QA Inspector observed ZPMC qualified welder Dong Yi Qun ID 059450 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP162-001.

The QA Inspector Dixon was informed by ZPMC QC Inspector Mr. Shen Xue Jun that ZPMC CWI Inspector CWI Li Yan Hua, and ABF personnel Kevin Chen were about to perform an initial three party visual repair inspection on deck panels DP190-001. Shen Xue Jun then requested that a Caltrans QA Inspector also performed a visual inspection on the deck panel.

After an agreement was reached by all parties on the repairs which need to be completed on the deck panel the QA Inspector assigned Caltrans lot number B59 and the inspection date in the space on the yellow tag which is pasted to the outside U-Ribs of the deck panels. The ABF and ZPMC personnel also signed and dated the tag indicating the inspection had been completed.

Bay 4 - Tower Double Diaphragm:

The QA Inspector randomly observed ZPMC qualified welder Zhu Xiaocai ID 068250 welding P421 + SA234

WELDING INSPECTION REPORT

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ESD1-SA234 B/B weld joint # 8. Qualified welder was observed welding in the 2G (horizontal) position utilizing shielded metal arc welding (SMAW) process with a 4.8mm diameter electrode, filler metal brand Excalibur 9018M MR, class E9018M manual. QA Inspector Dixon observed the ZPMC QC CWI Inspector Mr. Yu Dong Ping verifying that the welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). Welding parameters observed by QA Inspector Dixon appear to be in general compliance with the approved WPS-B-T-3312-Tc-P5.

The welding in progress generally appeared to conform to contract specifications.

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
