

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-003968**Date Inspected:** 26-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei, Chen Chih Chien**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, lap plates, bottom & side panels**Summary of Items Observed:****OBG Sub-assembly – Bay 1**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed deck panels in various stages of fabrication and approximately 55 ZPMC workers performing the following: grinding of butt weld joint in two U-ribs of extended length; machine bending of curve into U-ribs; cleaning with disc sander tool of steel on deck plates in layout patterns where the U-rib welds will be; GMAW root welding on both sides of three of five ribs, U-119, U-121, and U-345 to DP438-001; ZPMC MT of tack welds on DP444-001. Also present in this bay and monitoring the above noted welding were ZPMC CWI Sun Wei as well as ABF QC's Chang Bao Qian, Man-Kit Li, and Lu Yun. Items observed appeared to comply with project specifications.

Sub-assembly - Bay 2

QA Inspector randomly observed approximately 15 ZPMC workers using drill presses to drill patterned holes into various size and thickness lap plates. No welding was observed being performed in this bay.

Sub-assembly - Bay 3

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: FCAW-G of CJP joint at ribs to SP408; fitting and SMAW tacking of ribs to BP35A and grinding of tack welds; approximate 24mm patterned holes being drilled in T-rib ends for BP89; abrasive cleaning in rib welding layout pattern on various side plates. Also present in this bay were ZPMC CWI Chen Chih Chien and ABF QC's Li Jin Bo and Lei Tao. Items observed appeared to comply with project specifications.

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Summary of Conversations:

ABF QC Lei Tao informed QA Inspector that the FCAW-G weld about to be performed was a CJP weld at the tapered end of the ribs on SP408.

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
