

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-004498**Date Inspected:** 02-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi, Li Yan Hua**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**Summary of Items Observed:**

Heavy Duty Machine Shop- Bay 3

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final MT verification, 10% of the total linear distance of the 10% final MT performed by ZPMC on deck panels DP136-001 and DP324-002. No apparent indications were observed.

QA Inspector randomly observed 11 ZPMC workers performing the following: grinding of U-rib to deck panel welds on DP560-001, DP355-001, and DP409-001. There were 23 panels present in the bay. Also present in this bay were ZPMC CWI's Li Yan Hua and Chen Xi as well as ABF QC Wang Zhong Yuan and ZPMC QC Sun Yan Fei.

QA Inspector randomly observed flame preheating and FCAW-G in the horizontal position of: a plate stiffener to DP585-001, and U-ribs to DP560-001. ZPMC CWI Chen Xi was observed monitoring the latter of these operations.

QA Inspector performed initial VT on DP605-001 and DP540-001 with ZPMC QC behind Li Yan Hua and an unnamed ABF representative. QA Inspector later observed the yellow tag on both deck panels to display the name of ZPMC CWI Li Yan Hua (CWI) and an unnamed ABF representative. QA Inspector also notated initial VT indication concurrence with ABF and CWI on the yellow tag. All above items observed appeared to comply with project specifications.

Summary of Conversations:

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No significant conversations 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, 136-6471-0411, who represents the Office of Structural Materials for your project.

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