

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000825**Date Inspected:** 02-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	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 - Closed Rib Trial 2				

Summary of Items Observed:

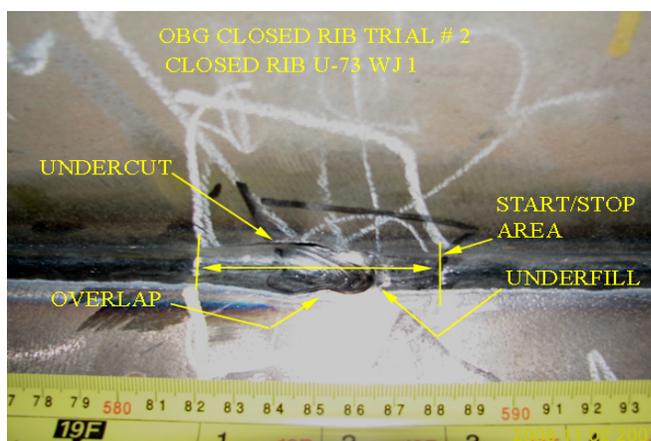
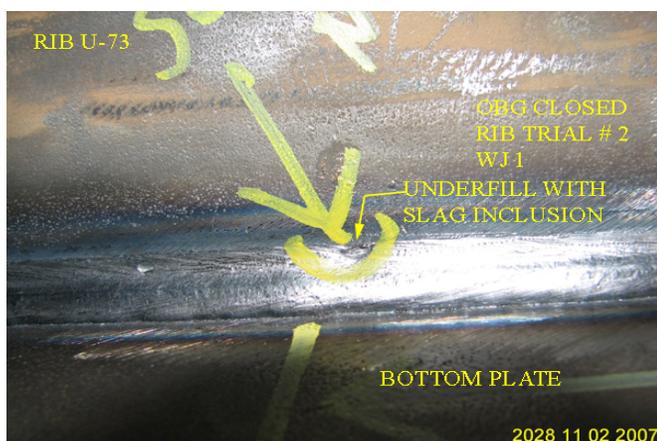
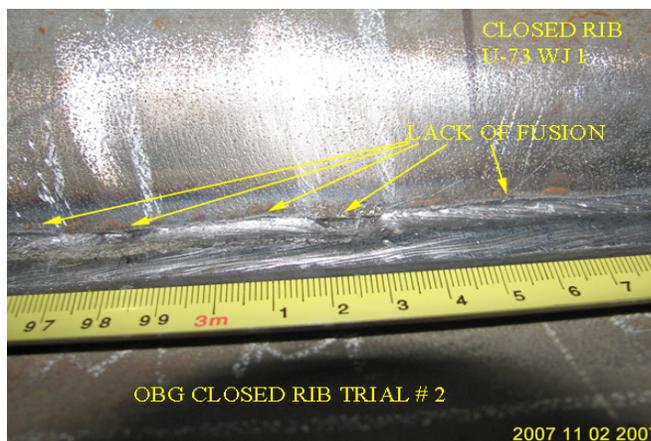
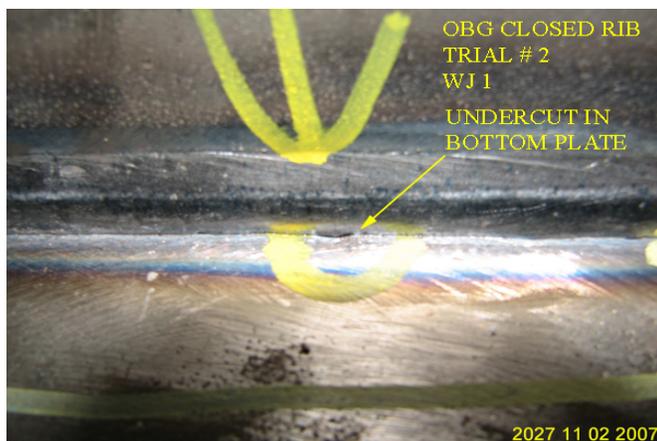
Orthotropic Box Girder (OBG):

Closed Rib Trials:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly verify and record the locations of welding discontinuities previously discovered during Visual Inspection (VT), by QA Personnel and marked directly on the OBG Closed Rib Trial Number 2 Assembly. The QA Inspector verified the locations of the previously marked welding discontinuities on Closed Rib (CR) U-73 Weld Joint (WJ) Numbers 1 & 2, CR U-01 WJ's 3 & 4 and CR U-75 WJ 5. The QA Inspector forwarded the recorded information to the Caltrans Lead QA Inspector on the day shift. The attached photographs provide additional detail.

WELDING INSPECTION REPORT

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Summary of Conversations:

During the verification and recording of the locations of welding discontinuities by the QA Inspector, ZPMC QA Representative Li Xiu Yang, asked the QA Inspector what the marking "US" meant? The QA Inspector informed Mr. Li that it was an indication of an undersized reinforcing fillet weld in that location. Mr. Li then informed the QA Inspector that there was no fillet weld and that the weld in question was a Partial Joint Penetration (PJP) groove weld. After some lengthy discussion and several sketches with soapstone, Mr. Li understood the difference between weld reinforcement and a reinforcing fillet weld.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer