

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: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000920**Date Inspected:** 15-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**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:	N/A	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:	Closed Rib	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

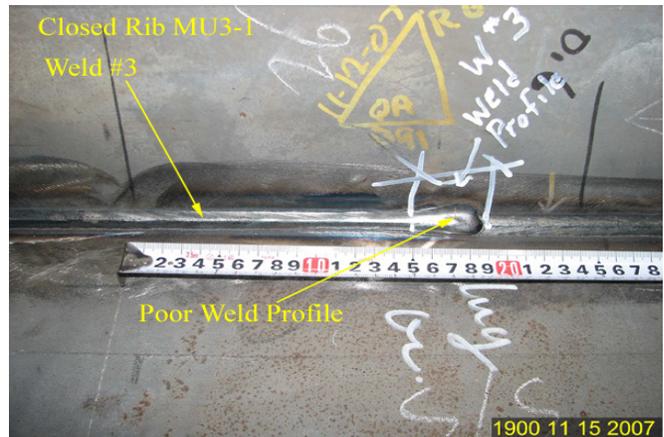
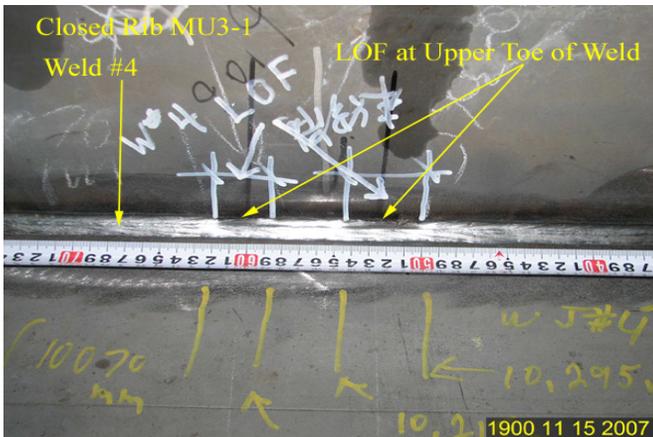
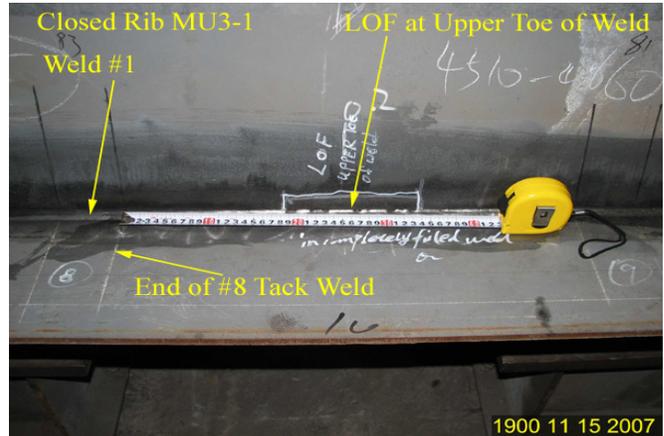
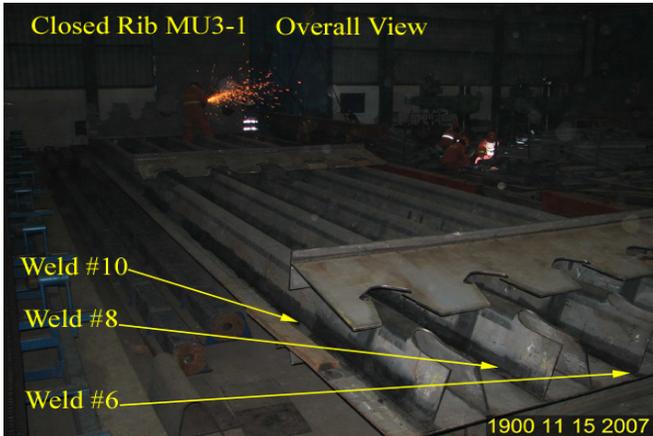
A visual weld inspection of the section of closed rib #MU3-1 was performed with the following discrepancies noted on welds number 1 through 10:

1. W#1 Lack of fusion (LOF) at upper toe of weld 185mm to 336mm from end of #8 tack weld.
2. W#1 LOF at upper toe of weld from 205mm to 311mm from #19 tack weld.
3. W#3 Excess weld buildup from 150mm to 195mm from #5 tack weld.
4. W#3 Poor weld profile from 305mm to 350mm from the end of #16 tack weld.
5. W#3 Poor weld profile from 350mm to 395mm from the end of #19 tack weld.
6. W#4 Poor weld profile from 140mm to 200mm from end of #5 tack weld.
7. W#4 LOF at upper toe of weld from 495mm to 545mm from end of #5 tack weld.
8. W#4 LOF at upper toe of weld from -20mm to +20mm from end of #6 tack weld.
9. W#4 LOF at 3 areas from -10mm to +12mm, 68mm to 100mm & 195mm to 210mm from start of #7 tack weld.
10. W#4 LOF at upper toe of weld from 48mm to 85mm from the start of #7 tack weld.
11. W#4 LOF at upper toe of weld from 495mm to 520mm from start of #7 tack weld.
12. W#4 LOF & poor weld profile from 360mm to 400mm from end of #19 tack weld.
13. W#5 Poor weld profile from 0mm to 90mm from end of #16 tack weld.
14. W#6 LOF & poor weld profile from 140mm to 190mm from end of #16 tack weld.
15. W#7 Undercut (UC) at 492mm to 558mm from end of #2 tack weld.
16. W#7 Poor weld profile from 150mm to 205mm from end of #5 tack weld.
17. W#7 UC at upper toe of weld from 485mm to 535mm from end of #6 tack weld.

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18. W#7 UC at upper toe of weld from -25mm to +25mm from start of #7 tack weld.
19. W#7 UC at upper toe of weld from 102mm to 185mm from start of #12 tack weld.
20. W#7 UC & poor weld profile from 300mm to 345mm from end of #16 tack weld.
21. W#7 Cold Lap at lower toe of weld from 250mm to 2585mm from end of #18 tack weld.
22. W#8 Poor weld profile from 115mm to 185mm from end of #5 tack weld.
23. W#8 LOF at upper toe of weld from 85mm to 95mm from start of #12 tack weld.
24. W#8 UC & poor weld profile from 295mm to 330mm from end of #16 tack weld.
25. W#8 Poor weld profile from 340mm to 380mm from end of #19 tack weld.
26. W#10 LOF & poor weld profile from 13mm to 70mm from start of #20 tack weld.



Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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.

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Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer