

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-001004**Date Inspected:** 13-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**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: Wu Ming Kai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 3 OBG:

The QA Inspector randomly observed ZPMC welding personnel utilizing the carbon air arc gouging process to back gouge butt splices in W21 X 57 I-Beams that are to be cut and used for T-Ribs. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC Torch Cutter utilizing a track mounted torch cutting apparatus, to cut W21 X 57 I-Beams into T-Ribs. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC Torch Cutter utilizing a track mounted torch cutting apparatus, to cut 22 millimeter thick A709M-345T2 steel plate to be used for I-Ribs. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC helper utilizing a grinder to blend tack welds attaching T-Ribs on Bottom Plate PL34B. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welding personnel preparing to weld the butt splice of Side Plate Sections PL70 A and PL70B at Weld Joint (WJ) SP009-01-001. Pre-heating panels had been removed and the

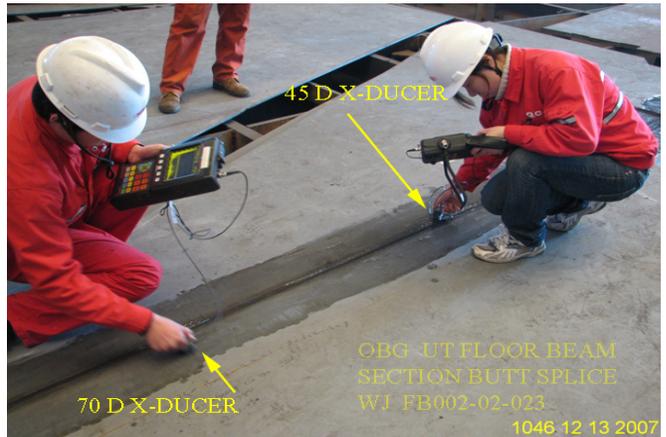
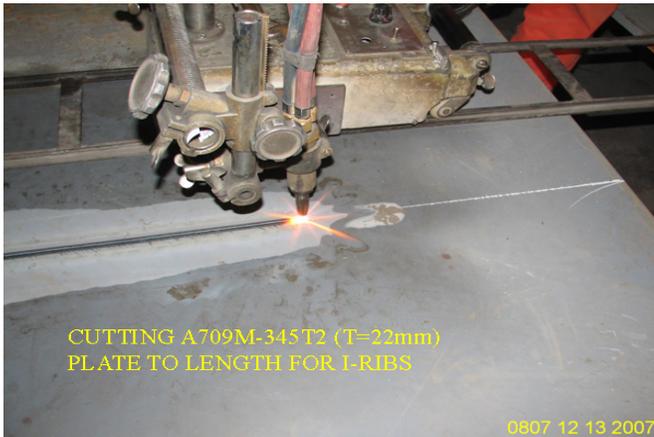
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weld area cleaned. Welding was not started because of malfunctioning of the submerged arc welding apparatus. The QA Inspector randomly observed the pre-heating panels being placed back over the weld joint.

Bay 7 OBG:

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technicians E Shuiqin and Xue Haizong, utilizing the Ultrasonic Testing (UT) Method, to examine Floor Beam Section WJ's FB002-02-023, FB008-01-023 and FB015-02-023. Each WJ was examined with with a lam scan, a 45 degree and 70 degree transducer. There appeared to be no recordable or rejectable indications. The QA Inspector randomly observed the NDT Technicians Mr. Xue and Ms. E, calibrate each transducer prior to use. The attached photograph provides additional detail



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Summary of Conversations:

There were no relevant conversations.

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
