

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-001130**Date Inspected:** 02-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC- Fu Gua Gang**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:** 77m, 89m, 114m and #1 deck mock-ups**Summary of Items Observed:**

On this date, the Caltrans Quality Assurance (QA) representative, John P. Tracy, conducted assessments while on site at Zhenhua Port Machinery Company (ZPMC) for Caltrans Project 04-0120F4-SAS. The following is the detailed review of the following observations:

Bay 1: Submerged Arc Weld (SAW) gantry welder is inactive. Caltrans representatives, Mr. Alfredo Acuna and Mr. Larry Viars, were present on the #1 Deck mock-up where they were capturing weld profile data that corresponded with Ultrasonic Testing (UT) inspection data from days previous. The Caltrans representative assisted these representatives by photographing diaphragm to closed U-rib attachment welds and significant weld discrepancies on various weld joints. Photographs were transferred to Mr. Acuna for reporting purposes.

Bay 2 operations: The 77m mock-up has ongoing thermal operations with multiple ceramic heating pads being placed on diaphragm to plate attachment welds. A to B attachment weld for joint MUA-MA1 D/F -14A under WPS-B-T-2232-B-U4b-F is also being heated for ZPMC welders Zhang Binghua (053316) and Wang Bing (048696) with ZPMC Certified Welding Inspector (CWI) Fu Gua Gang being present. MUSA-SA104 A/B-10 has root pass completed. Preheat was active and joint was in process for additional fill passes with ZPMC welder Jiang Xiaohu (066155) performing Shielded Metal Arc Weld (SMAW) process. No welding parameters were noted.

MUSB-MA25 and MUSB-MA26-1 and -2 shear links are idle and awaiting web to flange weld out.

89m MUSB-MA29 Cross Brace has had heat straightening operations performed and stiffener components that

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have been tack welded and have root passes already in place however, the component remains incomplete and inactive.

114m upper and lower mock-up sections are idle while awaiting the approved repair procedures.

Included below are digital pictures that support the observations recorded within this report.



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Summary of Conversations:

At the completion of the above stated operations, the ZPMC Certified Welding Inspector, Fu Gua Gang, reported that the parameters followed and their noted results were found to be in accordance with the criteria set forth within the contractual documents.

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:	Tracy,John	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
