

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-001307**Date Inspected:** 22-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:	Wu Ming Kai	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	

Summary of Items Observed:

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe and monitor the welding and Quality Control (QC) functions. While on site QA Inspector observed the following.

Bay 3

QA Inspector observed heat straightening using oxygen acetylene torch to correct distortion of Bottom Plate Weld SP039-01 which joins Plates PL89B to PL87A. QA Inspector observed ZPMC QC Inspector Toa Congana monitor that the head applied did not exceed 600 Degrees Celsius per the approved Heat Straightening Record HSR1(B)-126.

QA Inspector observed Magnetic Particle Testing Method (MT) performed at locations where tack welds were removed on Bottom Plate Welds SP035-01-07 and SP035-01-08. ZPMC MT Inspector Caixinxin identified and marked linear indications that required further grinding. QA Inspector verified that ZPMC MT Inspector Caixinxin has current certifications and as approved in the Self Anchoring Suspension (SAS) Welding Quality Control Plan (WQCP).

QA Inspector observed preheat of Bottom Plate Sub Plate at I-Rib SP-002-01-007 per approved Critical Welding Repair Report (CWR) #B-CWR012 and Welding Procedure Specification (WPS) 345-FCAW-1G(1F)-Repair. QA Inspector observed ZPMC QC Inspector verify that welding current was within the parameters of the approved WPS. Prior to welding on the actual part, welding on scrap material was performed to adjust and verify that the current is within the parameters of the approved WPS.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

At this stage of fabrication, all items observed appear to comply with the requirements of the Standard Specifications, contract Special Provisions, approved drawings, Welding Code AWS D1.5 (2002) and approved Welding Procedure Specification. Photographs shown below were shot with the camera date and time set using the Pacific Standard time zone.



Summary of Conversations:

General communications took place between the QA and QC Inspector.

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: Quintana, Gabriel

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer
