

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-001417**Date Inspected:** 12-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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:** WT Stiffeners**Summary of Items Observed:**

This QA Inspector arrived at ZMPC for observation of the SAS bridge fabrication. The QA Inspector worked with QA Inspector Paul Dawson for orientation and witnessing of the orthotropic bridge deck components. The QA inspector observed ZMPC personnel using a wire cone style wheel to clean the tack weld on the "T" shaped stiffeners. No welding was performed on this QA inspector's shift. The QA Inspector verified the WPS's associated with the fillet welds and splicing of the "T" joints. WPS numbers are as follows; WPS-B-T-2233-B-U2-F which is to be used for the splicing of the T shapes and WPS-B-T2132-3 which is to be used for the fillet welds for the T shapes to the flat plates. QA inspector Dawson informed the QA inspector of issues associated with the tack welds there has been longitudinal and transverse cracking evident from periodic magnetic particle testing on random weldments. ZPMC was informed of the findings and is working on eliminating the issue surrounding the cracking problem.

Summary of Conversations:

Conversations with QA Inspector Paul Dawson in regards to orientation of WT Stiffeners

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Cochran, Jim	QA Reviewer
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