

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-001483**Date Inspected:** 18-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:** Cui Yi Ru**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 (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Caltrans QA Inspector observed ZPMC perform repair of floor beam cracks by grinding at various fillet weld locations. At this time ZPMC has not ground any further than 2mm into the base metal at all excavated areas. The Caltrans QA Inspector addressed as to whether ZPMC would be required to apply the AWS D1.5 (2002) requirement of excavating beyond 50 mm of the crack as required in AWS D1.5 (2002) section 3.7.2.4 for transverse cracks. It was concluded by the Caltrans QA Team that the 50mm excavation requirement would not be applicable since the cracks occur transverse to the length of the fillet weld and that such excavations would require excavating into the base material where no weld was applied. The Caltrans QA Team added that assurance would have to be provided by ZPMC magnetic particle (MT) testing technicians to verify that cracks did not propagate into base material beyond the fillet weld transverse crack locations. Also Caltrans QA Inspectors will verify ZPMC MT findings with their own MT Inspection on all excavated areas.

Summary of Conversations:

No relevant conversations spoken on this date.

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:	McClendon, Timothy	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

Reviewed By:	Cuellar, Robert	QA Reviewer
---------------------	-----------------	-------------
