

**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-001603**Date Inspected:** 19-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huan Lan Nan**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:**

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 1 OBG:**

The QA Inspector performed Visual Inspection (VT) on Deck Plate DP057-001 Weld Joint (WJ) Numbers 001 through 010, and recorded random observations on a separate VT spreadsheet. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Welding operators utilizing the Submerged Arc Welding (SAW) Process with gantry mounted welding apparatus, to perform Production Monitoring Test (PMT) for Deck Plate DP059-001, WJ's 1, 2, 3 and 4. The observations and welding data, were recorded by the QA Inspector on a separate PMT spreadsheet.

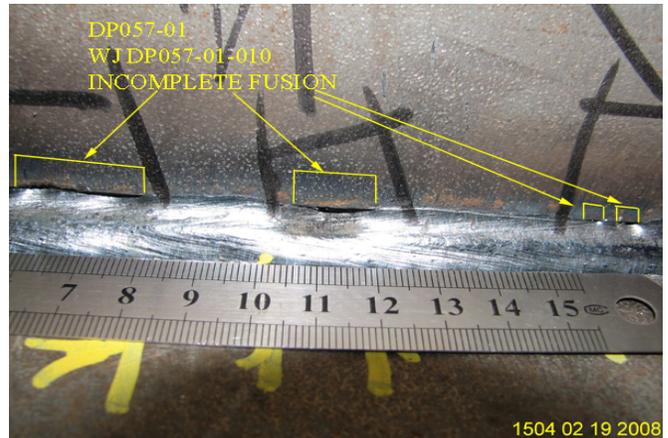
The QA Inspector randomly observed ZPMC welding operators utilizing the SAW Process with gantry mounted welding apparatus, to weld onto Deck Plate DP059-001, WJ's 001 through 010. The observations and welding data, were recorded by the QA Inspector on a separate production spreadsheet. The attached photographs provide additional detail.

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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Franco,Charlie

Quality Assurance Inspector

**Reviewed By:** Cochran,Jim

QA Reviewer

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