

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001698**Date Inspected:** 15-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:** Sun Wei**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.

The QA inspector completed visual weld inspection on closed rib partial joint penetration welds, on production panel DP-006-001, weld # 1 and weld # 2 on rib # U93 and U142, weld # 3 and weld # 4 on rib # U156 and U143, weld # 5 and weld # 6 on rib # U92 and U11 and weld # 7 and weld # 8 on rib # U83 and U16. The results of this visual inspection are as follows. Photographs of random weld defects on this deck panel can be seen below.

Weld #1 - thirteen (13) total indications, three (3) incomplete fusion, five (5) underfill, four (4) over lap and one (1) oversize.

Weld #2 - twenty-seven (27) total indications, one (1) oversize, eight (8) underfill, four (4) over lap, one (1) undersized, two (2) undercut, and eleven (11) incomplete fusion.

Weld #3 – three (3) total indications, two (2) underfill and one (1) incomplete fusion.

Weld #4 - eleven (11) total indications, two (2) underfill, four (4) incomplete fusion, two (2) over size, and three (3) overlap.

Weld #5 - twenty-three (23) total indications, four (4) underfill, one (1) oversize, fifteen (15) overlap and three (3)

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incomplete fusion.

Weld #6 – fourteen (14) total indications, three (3) over lap, five (5) incomplete fusion, one (1) over size and five (5) underfill.

Weld #7 – twenty-four (24) total indications, three (3) incomplete fusion, fifteen (15) underfill, five (5) over lap and one (1) over size.

Weld #8 – forty-nine (49) total indications, two (2) over lap, thirty-eight (38) incomplete fusion, and nine (9) under fill.

Visual Tracking Record is being maintained on site for reference and has been forwarded to the assistant structural materials representative Mr. Ady Velasco.

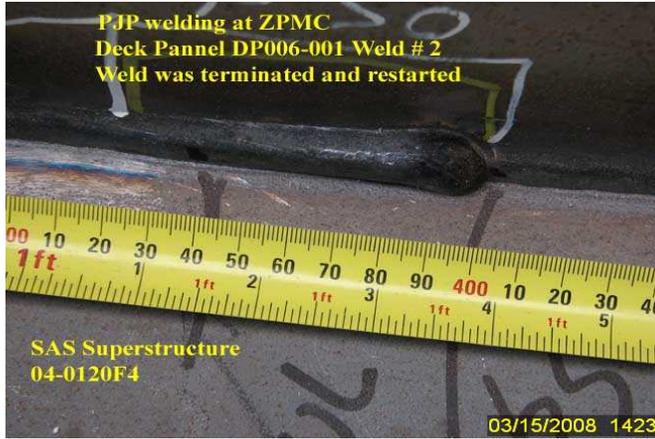
This QA inspector also marked areas, on PMT for deck panel #DP0044-001 and PMT for deck panel #DP075-001 and DP108-001, where macro test samples are to be removed by ZPMC personal in order to perform macro etch testing.

This QA inspector also witnessed ZPMC UT level II technician Xue Hai Rang performing UT testing on PMT for deck panel DP003-001 and PMT for deck panel DP108-001, Caltrans QA personal will perform UT verification at the earliest opportunity.



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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.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
