

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-001728**Date Inspected:** 16-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 deck panel DP-043-001, weld # 1 and weld # 2 on rib # U87, weld # 3 and weld # 4 on rib # U90, weld # 5 and weld # 6 on rib # U116, weld # 7 and weld # 8 on rib # U89 and weld # 9 and weld # 10 on rib # U83. The results of this inspection are as follows.

Weld # 1 - thirty (30) total indications, five (5) incomplete fusion, four (4) underfill, seven (7) over lap and fourteen (14) oversize.

Weld # 2 - sixteen (16) total indications, two (2) underfill, twelve (12) over lap, and two (2) incomplete fusion.

Weld # 3 - twelve (12) total indications, five (5) underfill, four (4) over lap, and three (3) incomplete fusion.

Weld # 4 - nine (9) total indications, one (1) underfill, one (1) incomplete fusion, and seven (7) overlap.

Weld # 5 - nine (9) total indications, four (4) underfill, four (4) overlap and one (1) incomplete fusion.

Weld # 6 - sixteen (16) total indications, ten (10) over lap, two (2) incomplete fusion, two (2) over size and two (2)

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underfill.

Weld # 7 – twelve (12) total indications, one (1) incomplete fusion, five (5) underfill, and six (6) over lap.

Weld # 8 – ten (10) total indications, four (4) incomplete fusion, three (3) oversize and three (3) under fill.

Weld # 9– seventeen (17) total indications, thirteen (13) over lap, and four (4) under fill.

Weld # 10 – fifteen(15) total indications, ten (10) over lap, two (2) incomplete fusion, one (1) over size and two (2) under fill.

The QA inspector also completed visual weld inspection of the following closed rib partial joint penetration welds, on production deck panel DP-003-001, weld # 1 and weld # 2 on rib splice # U220 and rib # U2, weld # 3 and weld # 4 on rib splice # U161 and rib # U3 and weld # 5 on rib splice # U162 and rib # U144. The remainder of welds on this deck panel will be inspected at the earliest opportunity. The results of this inspection are as follows.

Weld # 1 - twelve (12) total indications, three (3) incomplete fusion, eight (8) underfill, and one (1) oversize.

Weld # 2 - seven (7) total indications, four (4) underfill, two (2) over lap, and one (1) incomplete fusion.

Weld # 3 – sixteen (16) total indications, four (4) underfill, one (1) over lap, two (2) over size and nine (9) incomplete fusion.

Weld # 4 - fourteen (14) total indications, five (5) underfill, two (2) incomplete fusion, two (2) over size and five (5) overlap.

Weld # 5 - ten (10) total indications, seven (7) underfill, two (2) overlap and one (1) incomplete fusion.

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

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 Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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