

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-001781**Date Inspected:** 20-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:** Chen Xi**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 deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present During the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay 1

QA visually inspected completed welds on deck panel DP-216-001. All welds that were inspected appeared to exhibit some degree of lack of fusion, overlap and/or under fill. QA was unable to complete the visual inspection of this panel before the end of the shift. QA observed two American bridge/Fluor (ABF) Quality Control inspectors visually inspecting completed welds on one of the other deck panels in bay one.

U-Ribs U-32 and U-151

QA observed ZPMC Quality Control (QC) inspectors perform Magnetic Particle Test (MT) on excavated areas of the Complete Joint Penetration (CJP) splice welds on two of the U-Ribs in which rejectable indications were discovered during Ultrasonic Testing (UT) of the CJP splice welds. Both ribs had one defect each. The excavated area on rib U-32 measured 8mm deep, 20mm wide and 70mm in length. It is located on the outside of the rib in the center of the bend. The excavated area on rib U-151 measured 7mm deep, 20mm wide and 80mm in length. It is located on the outside of the rib in the center of one of the flat sides. (see attached Photos) Following the MT, ZPMC welding personnel performed the repair per the repair procedure R787-QCP-900. QA observed ZPMC QC

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

personnel verify welding parameters for compliance to the applicable WPS. The Parameters were as follows:

Volts: 25.5 Amps: 210 Travel Speed: repaired areas were too short to accurately determine travel speed.



Summary of Conversations:

No significant conversation were held toay regarding this project.

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:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
