

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-001929**Date Inspected:** 26-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Sahnghai, China

CWI Name:	N/A	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:** Orthotropic Box Girder(OBG)& Tower Diap**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspectors Roscoe Dixon, and Charles Franco were present at the time requested to perform and record measurements of weld indications for one u-rib production deck panel for the Orthotropic Box Girder (OBG) which had been identified earlier by ZPMC QC, and Caltrans QA Inspectors on previous inspections.

The measurements were performed on material at the following locations.

OBG outside storage area:

The Caltrans QA Inspector performed visual inspection on the completed submerged arc welding, (SAW) cover pass welds and partial joint penetration (PJP) welds joining the closed rib to deck panel DP079-001, u-rib U-88, welds 1 and 2; u-rib U-84, welds 3&4, and welds U-154 welds 5&6, u-rib U-155 welds 6&7, u-rib and U-137 welds 9 &10.

Bay 1 OBG:

The Caltrans QA Inspector performed visual inspection on the completed submerged arc welding, (SAW) cover pass welds and partial joint penetration (PJP) welds joining the closed rib to deck panel DP055-001, u-rib U-151, weld# 1 and 2; u-rib U-152, welds 3&4, u-rib U-85 welds 5&6, u-rib U-79, welds 7&8 and U-100, welds 9&10.

The Caltrans QA Inspectors measured the weld indications which appeared to have the following deficiencies: welding overlap, oversized welds, under-fill, and incomplete fusion. These indications observed at the welds were

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marked in yellow by the QA Inspector with a paint stick along the distance from the “Y” axis, starting at the weld start to the weld completion end.

The weld indications observed were recorded on a Caltrans spreadsheet for future reference

Summary of Conversations:

As noted within the report shown above

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:	Dixon,Roscoe	Quality Assurance Inspector
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Reviewed By:	Hager,Craig	QA Reviewer
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