

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-002115**Date Inspected:** 11-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name: Wu Ming Kat
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Box Girder Panel**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to inspect the welding fabrication of Orthotropic Box Girder (OBG) Deck Panel# DP 409-001.

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 the deck panel DP409-001, u-rib U-63 Welds 1&2; u-rib U-36, welds 3&4, U-64 welds 5&6 and U-17 for weld 7 only. QA Inspector was not able to finish inspecting the remaining welds (8, 9 & 10) on deck panel DP 409-001 in the time allotted before shift end.

Bay 1 OBG:

The Caltrans QA Inspectors measured the weld indications which appeared to have the following deficiencies: Welding overlap, oversize welds, under-fill, base metal (tool marks) and incomplete fusion. These indications observed at the welds were marked in yellow by the QA Inspector with a paint stick.

The weld indications observed were sized and recorded on a Caltrans OBG deck panel spreadsheet report for future reference.

Summary of Conversations:

No significant conversations at the time of this report

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

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Kelsey,David	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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