

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-002176**Date Inspected:** 10-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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:** Monitor MT Testing**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Bay-7, Monitored Magnetic Particle (MT) testing being performed by ZPMC Level II technicians Chi Xin Xin and Zhou Dong Yun. The tests were being conducted on the welding on Floor Beams FB-014-04, FB-014-06, FB-014-03, FB-014-05, FB-014-01 and 100% of the welding on FB-025002.

Bay-8, ZPMC employees were observed grinding and prepping the weld joints on WSD1-SA372 A/B-3A and ESD1-SA32 A/B-10B.

Bay-8, SAW welder Xu Peipei #050323 was observed during the welding of the final cover pass on NSD1-SA248-1A. The welding parameters recorded were, Amps 603, Volts 29 to 32, Travel Speed 472 mm/min. and the Temperature was observed to be 215 degrees c.

Photographs were taken of Macro Etch Sample Lots DP-244/DP-382-2 and DP-085/DP-274. Due to insufficient time the down loading and dating of the photographs will be completed during the following work day.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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.

WELDING INSPECTION REPORT

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Inspected By:	Smith, David	Quality Assurance Inspector
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Reviewed By:	Hager, Craig	QA Reviewer
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