

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-002202**Date Inspected:** 29-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**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**Summary of Items Observed:**

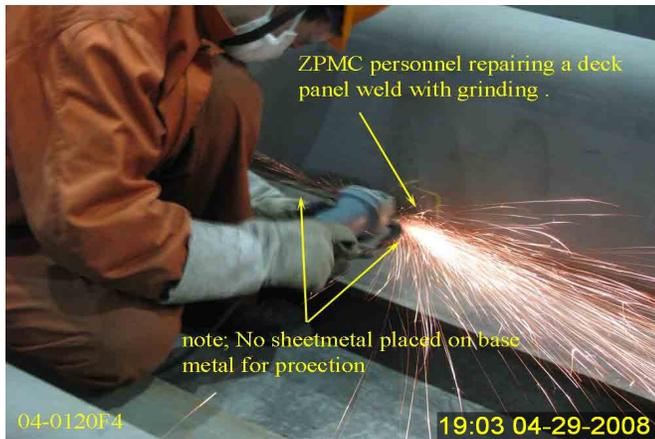
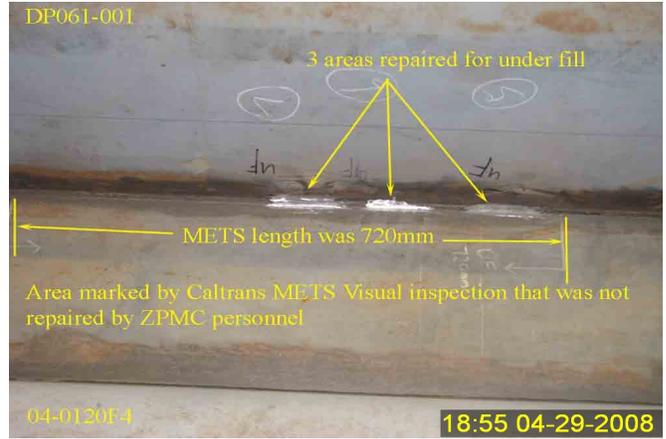
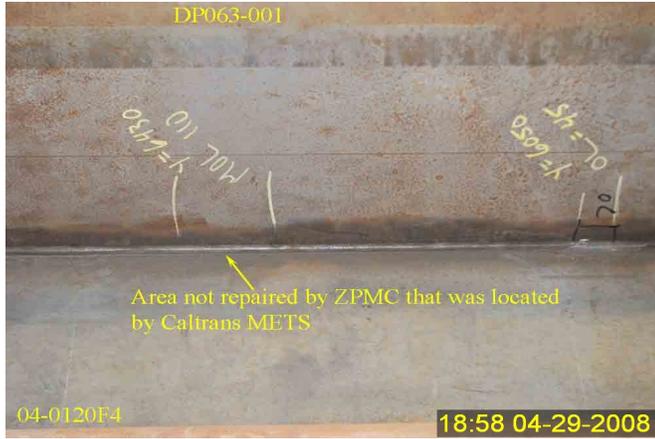
Deck Panel Repairs

Noted Conversation between This Quality Assurance (QA) inspector and ZPMC Certified Welding Inspector (CWI) Chen Xi upon this QA inspector observation for the deck panel repairs it was observed that ZPMC was not repairing all location marked by American Bridge/flour (ABF) and Caltrans METS (CT METS) inspectors. When this QA inspector asked Mr. Chen Xi about this it was stated that his leaders had instructed him to repair the ZPMC marked location only. When asked about the ABF and CT METS locations it was relayed that they were not to repair them except if they corresponded with the ZPMC marked locations. This information was immediately relayed to task leader Robert Cuellar via phone.

During the QA observations it was observed that ZPMC was grinding under fill areas and blending them into the closed rib material to remove the defected locations. This QA noted that ZPMC performed a Magnetic Particle inspection on several locations that had been excavated to ensure soundness and removal of defects. Welder Xiang Jie was observed performing welding repairs with the Flux Cored Arc Welding (FCAW) process according to WPS-345-FCAW-2G (2F)-Repair-1 With welding parameters being monitored by CWI Chen Xi assistant Quality Control (QC) personnel an appeared to be within the tolerances of the WPS stated above. This QA inspector did document which repairs were made and which were not made for the following deck panels; DP059-001, DP063-001, DP018-001 and DP014-001. These deck panels do not appear to be completed with the repair process at this time and are in process.

WELDING INSPECTION REPORT

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Summary of Conversations:

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

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
