

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-002246**Date Inspected:** 07-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**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:** Deck U-Rib Panels**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

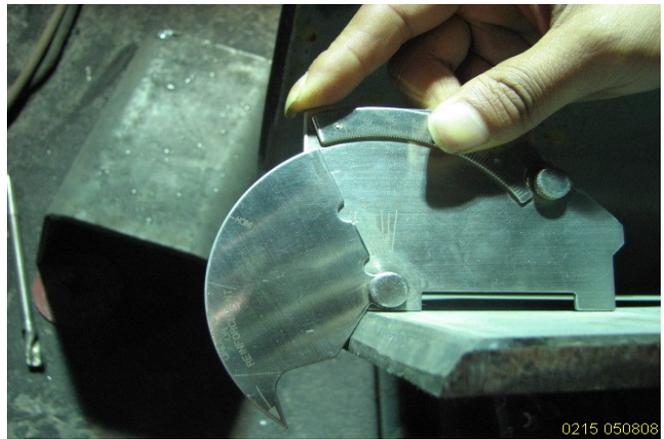
The Caltrans QA Inspector performed in-process visual inspection on the Gas Metal Arc Welding (GMAW) process for tack welding & fit-up on U-Rib segments to the OBG deck plates DP356-001 in Bay#3. QA Inspector also observed Flux Cored Arc Welding on the U-rib splices. QA Inspector randomly observed the ZPMC CWI Mr. Chen Xi monitoring welding voltage, pre-heat & interpass temperatures & cleaning, weld pass width, profile/size and travel speed per approved the approved WPS-B-T- 2342-U2 (GMAW) & WPS-B-T-2233-B-U2-F (FCAW).

The Caltrans QA Inspector observed the CWI measuring the bevel angle for the U-rib joint for the deck plate and U-rib weld splice bevel angle per the approved WPS-B-T- 2342-U2 (GMAW) & WPS-B-T-2233-B-U2-F (FCAW).

The in-process welding, fit-up & joint preparation observed by the Caltrans Inspector appears to comply with previously mentioned WPS, the approved drawings, the WQCP, Contract Special Provisions and AWS welding code D1.5 (2002). See attached pictures below in numeric order from left to right & top to bottom.

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Item	Description	WBS	Dwg No.	Status
1	Picture 1 / Weld joint 004 on DP356-001 CWI Chen XI checking bevel angle prior to fit-up on U-Rib weld joint to deck panel.	B-T-2342-U2		In-work
2	Picture 2 / DP410-001 Fit-up and FCAW CJP Welding of U-Rib splice	B-T-2233-B-U2-F		In-work
3	Picture 3 / DP356-001 CWI Chen Xi monitoring GMAW welding current parameters.	B-T-2242-U2		In-work
4	Picture 4 / DP410-001 CWI Chen Xi inspecting bevel angle prior to fit-up on weld 190.	B-T-2233- B-U2-F		In-work

Summary of Conversations:

General information conversations with the CWI in regards with the previously mentioned work.

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.

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Inspected By: Kelsey,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer