

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-002489**Date Inspected:** 14-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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:** Tower and OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 2:

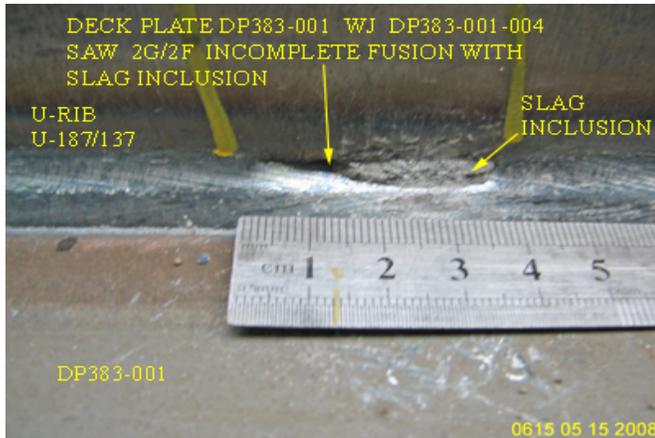
The QA Inspector randomly observed ZPMC welder Lin Wei ID Number 048532, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 1G (Flat Groove) Position, with ZPMC WPS WPS-B-P-2211-B-U3b, to tack weld Run On/Run Off Tabs to the start and stop edges of Skin Plate A at WJ WSD1-SA653A/F-1B piece marks SA653(W) to p1866(W). The QA Inspector randomly observed ZPMC CWI An Qing Xiang monitoring weld parameters. The weld parameters appeared to comply with contract requirements.

OBG Bay 2:

The QA Inspector randomly performed 100% Visual Inspection (VT) on Deck Plate DP383-001 Weld Joint Numbers (WJ) 002 through 007 U-Ribs 152/104, 187/137, 361/89 and 147/136 respectively. The QA Inspector recorded the data for the VT of WJ's 001/002, 003/004, 005/006, 007/008 and 009/010 on a separate spreadsheet. The attached photographs provide additional detail.

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Summary of Conversations:

There were no relevant conversations.

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

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer