

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-002547**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 Fabrication	

Summary of Items Observed:

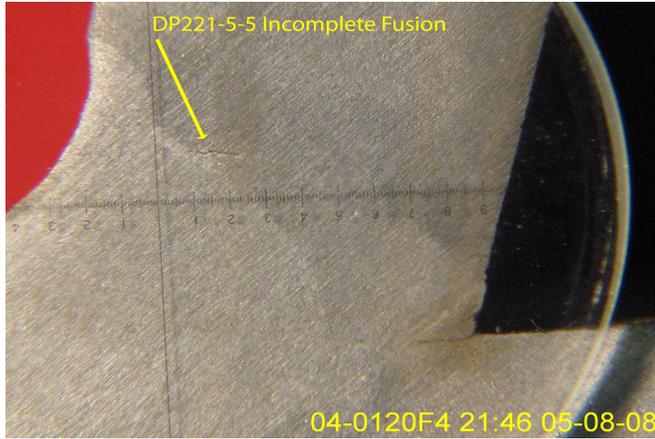
Orthotropic Box Girder (OBG) Fabrication:

Production Monitoring Tests Macro Etches

The QA Inspector performed visual and dimensional inspections of fifteen (15) each closed rib production macroetch weld samples labeled DP-221 representing deck plates DP-221-001 and DP-437-001 closed rib welds that were welded today. All fifteen macroetch samples appeared to contain penetration greater than 80 percent and macroetch sample DP-221-5-5 has a linear indication with what appears to be incomplete fusion and the other fourteen (14) macroetch samples appear to comply with project specifications. The results of these inspections are documented on an Excel spreadsheet titled "SAS OBG PMT Macroetch Log-05-08-2008" and a copy of this file is posted on the Caltrans "Team China" internal sever computer system. The QA Inspector also made digital photographs of each of the macroetch samples and copies of these photographs are posted on the Caltrans "Team China" common drive which accessible to Quality Assurance Task Leaders and Structural Materials Representatives. Below is a digital photograph showing the linear indication in macroetch weld specimen 221-5-5.

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Summary of Conversations:

No significant 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:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
