

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-002587**Date Inspected:** 29-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

The QA Inspector observed ZPMC qualified welding personnel perform the SAW welds joining the closed U-Ribs to deck panel DP-111-002. The QA observed 2 ZPMC QC inspectors in the vicinity of the welding operations including ZPMC CWI identified as Zhang Zhong and Sun Wei. There was also one American Bridge/Fluor (ABF) inspector identified as Wang Zhen Hua.

The QA and QC inspectors performed a random visual inspection of the welding in progress; the welds appeared to meet the requirements of the contract documents.

The QA Inspector completed a production panel welding reports for deck panels DP111-002 and DP-329-002. The reports are on file in the Caltrans QA office.

The QA Inspector observed ZPMC qualified welding personnel perform the SAW welds joining the closed U-Ribs identified on the QA production report for DP111-002 as group (A) U-291/114 welds 1&2 and U-Rib U-337/112 welds 5& 6.

The SAW welds joining the closed U-Ribs identified on the QA production report for DP329-002 Group (A) U-Ribs U-161/236 welds 1/ 2, U-190/240, and U-Rib U-185/239 welds 9/10. The group (B) U-Ribs identified as U-196/241 welds 3&4, and U-Rib U-190/329 welds 7&8. The QA and QC monitored the welding process

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continuously throughout the evening.

The welding parameters measured with the calibrated gages on the machines appeared to be in conformance with the posted WPS's.

Summary of Conversations:

As noted within the report shown 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dixon,Roscoe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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