

**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-002601**Date Inspected:** 08-May-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:** Li Yan Hua**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).

Bay 3 – New Tower Building

The QA Inspector observed ZPMC qualified welder Xu Guoyin ID 05944 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP002-001.

The deck panel repair welding in the progress on DP002-001 generally appeared to conform to contract specifications.

The QA Inspector continued and completed documentation of deck panel repairs performed by ZPMC to DP051-001 which was initially started on 05-07-07.

The QA Inspector observed ZPMC personnel performing grinding repair in the progress on DP002-001. During the QA observation the grinding repair work being performed on DP002-001 by ZPMC personnel did not appear to be in conformance with the approved repair procedure for Closed Rib Welds dated April 2 2008.

The QA Inspector informed ABF Inspector Warren Buehler that some weld areas noted as under fill discontinuity was being repaired by grinding to blend base metal to weld metal without adding new filler metal.

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# WELDING INSPECTION REPORT

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Mr. Buehler notified ZPMC QC Eric Jun who stopped the grinding of these areas, and Mr. Buehler informed the QA Inspector he was going to hold a training class on the repairs on 05-09-08 to insure uniformity of weld repairs to deck panels.

**Summary of 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dixon,Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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