

**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-002638**Date Inspected:** 23-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:** 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:** OBG/Tower**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 DP074-001, DP015-001, DP020-001.

The QA Inspector observed ZPMC perform two Critical Weld Repairs, (CWR) on deck panel DP018-002-001 CWR DP018-002-004. The CWR report was identified as BCWR077.

The QA Inspector observed ZPMC perform two Critical Weld Repairs, (CWR) on deck panel DP020-001-002, CWR DP020-001-006. The CWR report was identified as BCWR080.

The QA Inspector observed ZPMC personnel deliver and store seven deck panels identified as DP054-001, DP003-001, DP050-001, DP052-001, DP004-001, DP007-001, and DP006-002.

The QA Inspector observed four ZPMC personnel performing grinding of deck panel repairs, one welder performing FCAW welding on deck panel for repair of welds, one CWI Inspector, one personnel performing preheat of areas to be welded, and two ABF QC personnel identified as Kevin Chen and Ding Baohua.

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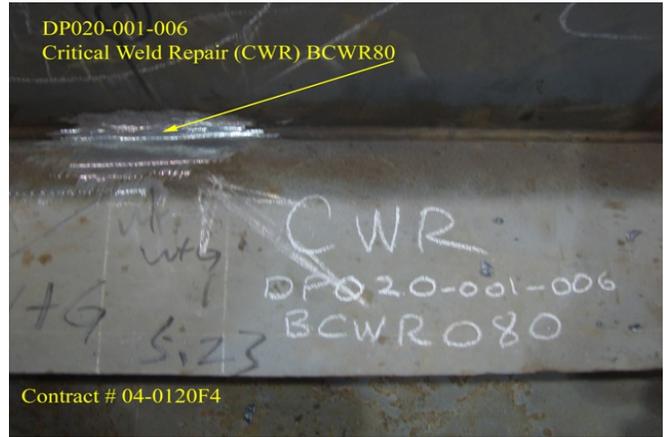
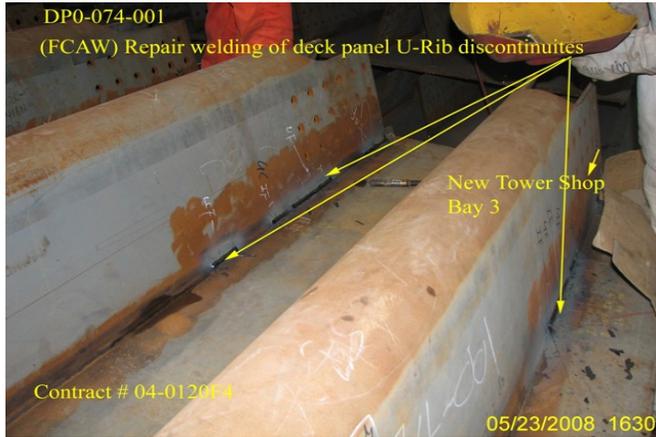
# WELDING INSPECTION REPORT

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The deck panel repair welding in the progress generally appeared to conform to contract specifications.



### 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.

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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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