

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002699**Date Inspected:** 16-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen chin Meng**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:** Side Plates, Bottom Plates, Floor Beams, Dec**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates, heat straightening of Side Plates and Bottom Plates.

Member identification and the work performed on the members are as follows:

Shop Welding:

SEG020A-028: Caltrans QA observed ZPMC personnel performing base metal repair of areas where strong-backs have been removed from the side plates identified as SP44B and SP56B. The areas of repair have been contoured by grinding and Magnetic Particle MT Tested by ZPMC personnel prior to the start of the repair welding. Welders and welding essential variables have been recorded below.

SEG020A-022: Caltrans QA observed ZPMC personnel performing base metal repair of areas where strong-backs have been removed from the side plates identified as SP44A and SP56A. The areas of repair have been contoured by grinding and Magnetic Particle MT Tested by ZPMC personnel prior to the start of the repair welding. Welders

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

and welding essential variables have been recorded below.

SEG020A-016: Caltrans QA observed ZPMC personnel performing base metal repair of areas where strong-backs have been removed from the side plates identified as SP43B and SP55B. The areas of repair have been contoured by grinding and Magnetic Particle MT Tested by ZPMC personnel prior to the start of the repair welding. Welders and welding essential variables have been recorded below.

OBG Jig Fixture (South):

Segment 3BE(SEG16A) Panel Point 23- Caltrans QA observed ZPMC personnel performing bevel preparation of the CJP weld joining FL2-2 South to FL1-1 South. The joint is offset laterally by 20mm but has not been tacked welded. ZPMC QC is aware of the misalignment and will correct the issue prior to welding the joint. Caltrans QA also observed ZPMC performing work to correct the misalignment of FL1-1(FB16) South. ZPMC personnel are using chain falls to pull the bottom of the member into the correct alignment on Segment C5. See attached Photo.

General Note:

All work observed, unless otherwise noted, appeared to generally comply with the contract documents.



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	Base Metal Repair	WPS-345-SMAW-100	Chen Meng	162	22	88mmpm	160 C	Welding Parameters are consist for all base metal repairs noted above. The welders are identified as 044772 and 037780

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lindenmuth,Mahlon	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Cuellar,Robert	QA Reviewer
---------------------	----------------	-------------