

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-002727**Date Inspected:** 30-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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:	Diaphragm plate closed rib deck panel	

Summary of Items Observed:

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

CWI Inspector: NA No welding observed

Per ZPMC UT inspection notification (00157) this inspector performed UT of the CJP section of the internal diaphragm plates (stiffeners) on the closed rib deck panel DP597-001. In addition random visual examination of welds (welds 105~124) appeared to conform to the approved drawings, Special Provisions and welding code AWS D1.5 2002 as verified by this inspector for DP597-001.

For DP551-001 this inspector observed at least 3 welds rejected by ZPMC UT technicians. QA UT was not completed on this panel until repairs are completed and welds accepted by QC UT.

The Caltrans QA Inspector performed Ultrasonic Testing (UT) verification of the QC UT Inspected and accepted welds 114, 115, 121, 122 for DP597-001. QA Inspector's visual and UT verification appears to be acceptable with AWS D1.5-02 section 6, table 6.3. Reference QA Ultrasonic Test Report TL-6027 dated 5/30/08 for specific test data.

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Item	Description	WBS	Dwg No.	Status
1	Above picture UT of the CJP closed rib diaphragm plate portion of the weld on DP597-001 welds 114, 115, 121 & 122.			

Summary of Conversations:

ZPMC QC Fu Yuhong assisted this inspector in verifying the minimum length of the CJP weld on the closed rib diaphragm plate referencing weld detail WD30A.

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:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
