

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-002728**Date Inspected:** 29-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:	Deck Panels	

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

The Caltrans QA Inspector Mr. David Kelsey performed Final Visual Testing (VT) and (MT) on DP025-001; partial penetration repair welds 001 thru 006. This inspector found the ZPMC repairs to be compliant with contract Special Provisions and welding code AWS D1.5 2002. This Inspectors results and repair locations were recorded on the OBG deck panel weld inspection report and turned into the appropriate personnel and filed in the deck panel log book.

This inspector also performed final visual testing (VT) on the partially repaired deck panel DP54-001 welds 001 ~ 010. This inspector only recorded the repairs completed by ZPMC up to this date. This inspectors' results were recorded on the OBG repair deck panel inspection report (DP54-001) and left on QA Inspectors William Clifford to be completed by later shifts.

The Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of the QC MT inspected and accepted welds. QA Inspector's MT verification appears to be acceptable with AWS D1.5-02 section 6.26.2.1 & 6.26.2.3 Reference QA Magnetic Particle Test Report TL-6028 dated 5-29-08 for specific test data.

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Item	Description	WBS	Dwg No.	Status
1	Picture at above left MT on skin plate transition weld SSDI SA18 of various welds			
3	Picture at right Measuring weld size on the repaired PJP weld on DP025-001 weld 001.			

Summary of Conversations:

None Noted.

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
