

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-002729**Date Inspected:** 24-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:** See observations**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 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

The Caltrans QA Inspector Mr. David Kelsey performed Final Visual Testing (VT) on DP074-001 partial penetration repair welds 001 thru 010 in Tower Shop Bay# 3. The results were recorded on the deck panel spread sheet which included the repair length and type of indication repaired and the repairs Y location. This Inspector noted that QC performed VT but that no MT has been completed by either ZPMC QC or Caltrans QA technicians and was so noted on the report/spreadsheet.

This inspector also performed and completed initial VT of the QC inspected welds on deck panel# DP548-001 welds 001-008. This inspector marked and measured visual indication such as under-fill, overlap, oversized, undersized and incomplete fusion. Results and the Y locations were recorded on the deck panel inspection form and copies turned into the appropriate personnel and added to the deck panel log book.

This inspector also noted two welders who started performing GMAW tack welding joining the U-Ribs to deck panel# DP588-001 at approximately 0415 in OBG Bay#1. This inspector also noted that no ZPMC QC CWI was present to monitor the welding from the time welding started at 0415 to when this inspector left the Bay# 3 at 0520. See conversations below noting ZPMC lead QC.

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No other observation took place during the shift by this inspector.

Summary of Conversations:

This inspector contacted by phone Mr. Wang Lu Testino ZPMC lead nightshift QC Inspector of the incident in Bay# 3 that no QC CWI has been present to monitor the tack welding for the last hour (0415 to 0515 & longer?). Mr. Testino stated that he was unaware that any welding was scheduled to be performed in Bay 3 at that time and that he had no CWI at this time to cover the welding operations. This inspector suggested to QC Mr. Testino to shut down welding operations until a QC CWI is available to monitor the welding. It is unclear if QC Mr. Testino followed this inspector's advice, welding was still continuing when I left Bay 3 and headed back to the office at 0520 to complete the night's reports. This inspector informed QC Mr. Testino that welding with no QC CWI longer than 30 minutes is in violation of the contract special provisions and an incident report will be submitted. QC Mr. Testino stated that he understood; no further conversations took place, reference this inspector's incident report dated 5-25-05.

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
