

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-002731**Date Inspected:** 20-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**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:** Tower & OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Bay 1:

The QA Inspector randomly observed ZPMC welder Li Huabei ID Number 059472, utilizing the Gas Metal Arc Welding (GMAW) Process in the 2G (Horizontal Groove) Position, with ZPMC WPS WPS-B-T-2342-U2(U-Rib), to tack weld Closed Ribs (U-Ribs) U-98, U-97, U-144 and U-143 to Deck Plate DP549-001 at Weld Joint (WJ) Numbers DP549-001-001 through DP549-001-008 respectively. The QA Inspector randomly observed ZPMC CWI Li Yanhua monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photographs provide additional detail.

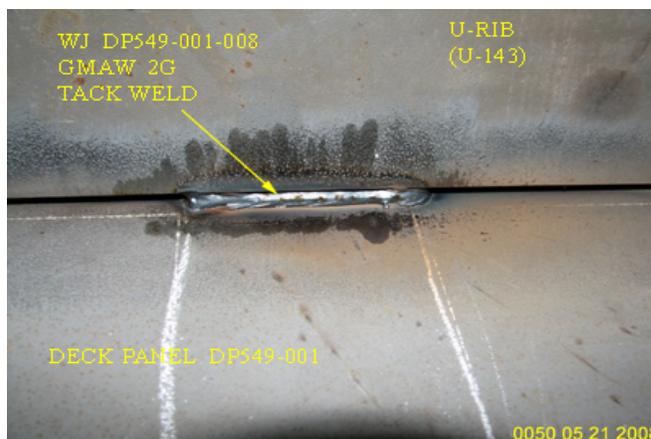
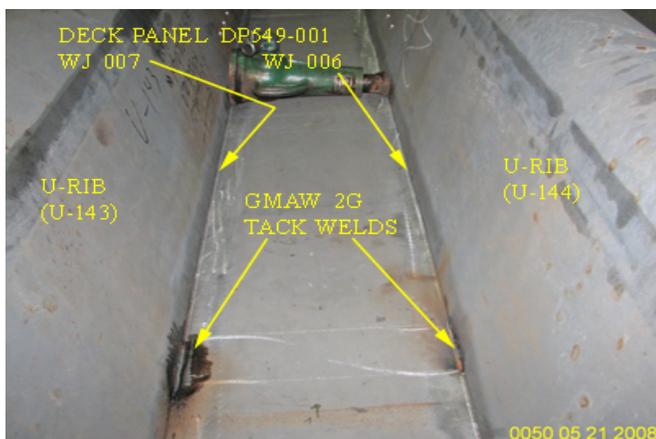
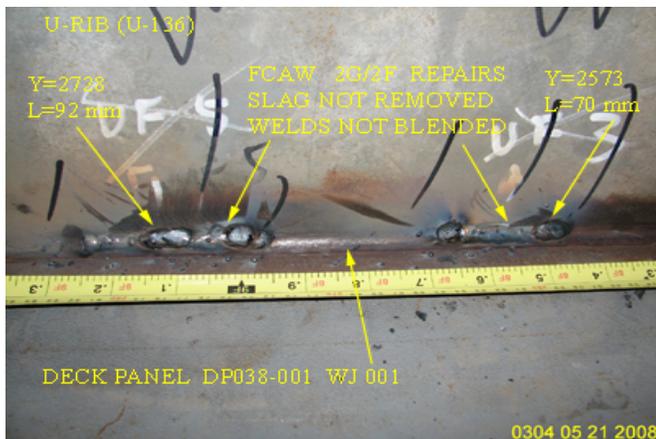
The QA Inspector performed Visual Inspection (VT) to WJ DP604-001-001 on Deck Panel DP604-001. The QA Inspector recorded the VT Inspection data on a separate spreadsheet.

New Tower Shop Bay 3:

The QA Inspector performed Visual Inspection of repairs to WJ's DP038-001-001 through DP038-001-004 on Deck Panel DP038-001. Inspection data recorded on a separate spreadsheet. The attached photographs provide additional detail.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

There were no relevant 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 remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
