

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-002736**Date Inspected:** 30-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Huang Wen-Pang/Sun Wei	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	

Summary of Items Observed:

VT DP406-001

This Quality Assurance (QA) arrived at ZPMC for visual inspection of the Orthotropic Bridge Girders (OBG) Deck Plates that were welded by ZPMC. Visual Inspection performed for information only and was determined to have the following discontinuities at multiple locations; Insufficient Fusion (IF) Over Lap (OL), Under Fill (UF) and over sized welds within the weldments that were inspected. The deck panel inspected was number DP406-001 welds 1 through 7. The locations and lengths of the discontinuities were recorded for tracking and distributed to the appropriate personnel for review.

Cracked tack weld FB016-013

During this QA inspectors continued observation in bay 7 it was noted that ZPMC was performing crack repair on a tack weld located on component number FB016-013 weld 009. Caltrans was notified prior to the beginning of the excavation by ABF representative David Larue. This QA inspector witnessed ZPMC personnel using a grinder to remove the crack and removal of the tack weld. ZPMC CWI Huang Wen-Pang was present during this operation and to monitor the complete removal of the crack and to maintain proper base metal depth. Once completed the CWI informed this QA inspector that Magnetic Particle inspection would be performed later in the shift and ZPMC would contact Caltrans QA to witness the testing.

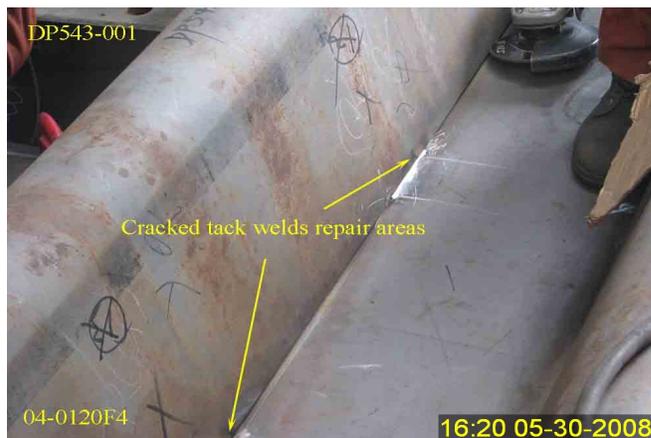
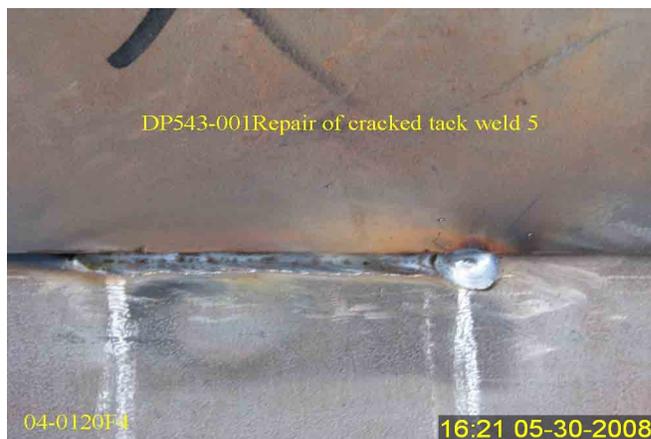
Cracked Tack welds DP543-001

This QA inspector also seen that ZPMC in bay 1 had performed crack repairs on deck panel number DP543-001. Cracks were as follows; weld 5 there 2 cracked tack welds and weld 1 there was 1 cracked tack. This QA inspector was informed by ZPMC CWI Sun Wei of these areas after the repairs had been completed. Caltrans was not informed of these repairs to witness as per the agreement between ABF and Caltrans. This QA inspector was also informed that ZPMC had performed Magnetic Particle inspection for the excavations and again no notification was

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given for Caltrans to witness.



Summary of Conversations:

As noted in contents above.

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 Pat Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Riley, Ken

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer