

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-002757**Date Inspected:** 28-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:** Changxing Island**CWI Name:** 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:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual Testing (VT) of the Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector requested an update of Deck Panels DP543-001 and DP563-001 tack weld repair from the ZPMC OBG night shift Certified Welding Inspector (CWI) Mr. Sun Wei. Mr. Sun stated that ZPMC repairs were still in progress and repairs would resume on day shift.

The Caltrans QA Inspector performed visual inspection of OBG 13.560 meter deck panel DP589-002 (welds 001 through 008) U-rib Partial Joint Penetration (PJP) welds. Visual testing of welding was performed in accordance with contract documents. The following discontinuities were found during inspection on the Submerged Arc Welding (SAW) cover pass, incomplete fusion, overlap, undercut, underfill, undersize and oversize welds. Welding discontinuities were marked on deck panel with a permanent marker, length and Y location recorded. Visual Inspection results were distributed to the appropriate personnel for review. A summary of discontinuities on inspected U- rib PJP welds are listed below.

DP589-002

DP589-002-001, Incomplete Fusion 9 areas, Underfill 7 areas, and Undercut 4 areas

DP589-002-002, Underfill 7 areas, and Undercut 1 area

DP589-002-003, Underfill 1 area, and Overlap 1 area

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

DP589-002-004, Underfill 20 areas

DP589-002-005, Incomplete Fusion 1 area, Underfill 4 areas, and Undercut 2 areas

DP589-002-006, Underfill 11 areas

DP589-002-007, Incomplete Fusion 5 areas, Underfill 25 areas, Overlap 1 area, and Oversize 1 area

DP589-002-008, Incomplete Fusion 4 areas, and Underfill 23 areas, Undersize 1 area, and Overlap 1 area

Summary of Conversations:

As identified within the contents of this report.

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:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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