

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-002835**Date Inspected:** 03-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. Chen**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 Segments**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates, heat straightening of Side Plates and Bottom Plates.

South Jig Fixture:

*Segment 3AE- Caltrans QA Lindenmuth observed that the flange, located on the floor beam segment FL2-2, has been flame cut on the the North and South ends of the flange. The flame cut lengths measured approximately 200mm on both ends. The ends of the flanges have been removed so that the fit-up of the FL1 North and South segments could be positioned in the jig fixture and aligned without being obstructed by the flange ends of the FL2 segment.

*Segment 4BE- Caltrans QA Lindenmuth observed ZPMC personnel performing welding on the Complete Joint Penetration (CJP) weld joining the segments 4BE-C5 to 4BE-D6. The welding process observed was SAW and the performing the welding was identified as Wang Min (ID#:04846). Welding essential variables have been noted and recorded below.

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Shop Welding:

*Caltrans QA Lindenmuth observed the welding of the CJP welds joining the Bottom Plates BP56A and BP110A. The bottom plates have been incorporated into SEG022A-006. The root pass has been welded by welder Hong yong Li (ID# 044801). No welding essential variables could be noted due to ZPMC personnel stopping for lunch at the time of Caltrans QA's arrival.

Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	4BE-C5 to 4BE-D6	WPS-B-T--223(2)	T C.M. Chen	650	32	575mmpm	68 C	

Summary of 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:	Lindenmuth,Mahlon	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
