

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-002863**Date Inspected:** 06-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**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:** OBG Deck Panel Repairs**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 3 – New Tower Building

This QA Inspector randomly observed ZPMC welding and quality control personnel performing inspection, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. The deck panels in repair process are designated as: DP043-001

In process deck panel repairs appear to be progressing in compliance with Caltrans Engineer Approved Repair Procedure.

The deck panels located in Tower Shop Bay #3 are designated as:

DP042-001 DP080-001 DP055-001 DP078-001 DP075-001 DP043-001
DP026-001 DP015-001 DP006-001 DP074-001 DP038-002 DP072-001
DP031-001 DP068-001 DP030-001 DP005-001 DP020-001 DP067-001
DP003-001 DP037-001 DP077-001 DP001-001 DP052-001 DP051-001
DP050-001 DP049-001 DP025-001 DP065-001 DP042-002 DP038-001
DP054-001

This QA Inspector performed an initial visual confirmation of the extent of rejectable indications contained in deck panel designated as DP003-001. This visual confirmation was performed in conjunction with ABF

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

representative Warren Buehler and ZPMC representative Li Yanhua.

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.

Deck panel PJP tracking tag for visual indication repairs.

SFOBB QA VERIFICATION TAG			
IN-PROCESS			
SUBASSEMBLY <u>DP043-001</u>			Tag No. 0000000002
INSPECTIONS		REPAIRS	
	ZPMC	ABF	CT
FVT			
UT			
MT			
RT			
Dimen.			
Notes:			

06/06/08 9:10

Summary of Conversations:

At approximately 07:30 hours this QA Inspector attended a meeting with ABF representative Warren Buehler, ZPMC representative Li Yanhua, and Caltrans representative Dave McClary to discuss the proposed tagging and tracking system for Orthotropic Box Girder deck panel repairs. In this meeting attending parties agreed that prior to initiation of repair procedures representatives from ABF, ZPMC, and Caltrans would together to confirm visually the extent of rejectable indications for each deck panel. It was also agreed that after repair procedures had been completed representatives from the afore mentioned bodies would again together confirm visually that repairs had been completed and found to be visually acceptable per Caltrans Engineer Approved Repair Procedures.

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:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
