

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-002879**Date Inspected:** 11-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Chen Xi**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:** Deck Panel & PMT**Summary of Items Observed:**

The Caltrans QA Inspector performed in-process visual inspection and monitoring of the production monitoring test (PMT) using the GMAW & SAW processes per WPS-B-T-2342-UI (urib)-3. This inspector monitored, recorded and sampled the PMTs for DP561-001. ZPMC had to run two sets of PMTs with the first set failing VT for excess overlap, the second set passed VT & UT. Samples were marked for each weld and thermal cut out for macro examination. All results were recorded on PMT inspection sheet. The in-process welding, fit-up & joint preparation observed by this Inspector appears to comply with previously mentioned WPS, the approved drawings, the WQCP, Contract Special Provisions and AWS welding code D1.5 (2002).

No other observations by this inspector.

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Item	Description	WBS	Dwg No.	Status
1	Picture above left ZPMC thermal cutting out macro samples marked by QA.			
2	Picture above right MT of tack welds on PMT			

Summary of Conversations:

None noted.

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

Inspected By:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
