

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-002902**Date Inspected:** 26-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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 Sections**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.

North Jig Fixture:

*Segment 3BW- Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel performing welding on the Complete Joint Penetration (CJP) welds joining the side plate segments identified as 3BW-C5 and 3BW-E7 to the bottom plate segment identified as 3BW-D6. QA Lindenmuth noted and recorded the welding essential variables below.

Shop Welding:

*Segment 020A-001- Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel performing backgouging (Air Carbon Arc) on the CJP weld joining the side plates SP16A and SP24A. The approximate cumulative linear length of the backgouged area is 400mm. The backgouging was performed on the root side of the weld in order to remove discontinuities discovered by ZPMC QC personnel who had performed Ultrasonic Testing (UT) of the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

weld.

*QA Lindenmuth observed that the diagonal connection plates located on the 3AE-PPO22 floor beam FL2-1, have been welded to the bottom flange of the FL2-1. ZPMC personnel were in the process of grinding the weld faces at all four connection plates.

General Note: All work observed today, unless otherwise noted, appeared to comply with the contract documents.

Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	3BW-D6 to 3BW-E7	WPS-B-T-2232-1	C.M. Chen	600	30	575mmpm	68 C	Welder ID: 045265 Weld Process: SAW

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