

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-002979**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu Ming Kai	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:

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

Bay 3--New Tower Building

The QA Inspector randomly observed ZPMC welding and QC personnel performing grinding of repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-five (35ea) deck panels are inside the shop. The QA Inspector spent the first part of the shift briefing QA Inspector Roscoe Dixon of the new repair procedures and the new repair tagging system. Repair work in this bay was monitored by QA Inspector Roscoe Dixon on this date.

OBG-Bay 4

At the request of QA Task Leader Albert Carreon, the QA Inspector verified the approval of three (3ea) critical weld repairs (CWR) that were already in-process located on the stiffener plate fillet welds for side panel designation SP414-001-005 (CWR #110), SP414-001-007 (CWR #111) & SP414-009 (CWR #112). The QA Inspector reviewed the applicable CWR documentation and informed Mr. Carreon that they were approved by Caltrans on 6/19/08. The QA Inspector observed ZPMC Certified Welding Inspector personnel Wu Ming Kai.

OBG-Bay 1

The QA Inspector witnessed ZPMC personnel performing Magnetic Particle Testing (MT) verification on 100% of

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the tack welds for DP602-001. The QA Inspector noted several areas that were marked up for relevant indications and ZPMC personnel performing additional grinding to remove the indications. Once the MT was complete, the inspection was signed off by ZPMC MT personnel Cai Xin Xin. Later in the shift the QA Inspector performed 10% MT verification on these same tack welds and found two (2ea) relevant indications located on two (2ea) separate tack welds. The first indication was located at Y location 1845 mm on weld joint 006, measuring approximately 70 mm in length. The second indication was located at Y location 1855 on weld joint 008, measuring approximately 20 mm in length (see digital images below). This information was relayed to QA Task Leader Albert Carreon and ZPMC QA personnel Fu Yuhong. Later in the shift the QA Inspector observed the areas where these indications were found appeared to have been ground and re-inspected by ZPMC personnel. The QA Inspector also performed MT and verified the indications had been completely removed.



Summary of Conversations:

As noted above in 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.

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Inspected By:	Leach,Ed	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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