

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-003023**Date Inspected:** 19-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:** Wang Sei Fa**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: DP027-001 and DP037-001.

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 DP078-001 DP070-001 DP080-001 DP075-001 DP072-001
DP028-001 DP027-001 DP031-001 DP068-001 DP030-001 DP071-001
DP051-001 DP050-001 DP049-001 DP026-002 DP037-001 DP005-001
DP001-001 DP030-002 DP074-001 DP054-001 DP077-001 DP038-002
DP065-001 DP006-001 DP042-002 DP038-001 DP025-001 DP067-001
DP055-001 DP052-001 DP003-001

Visual Testing After Repair

This QA performed Visual Testing (VT) of completed deck panel repairs. The weld repairs were found visually

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acceptable per Caltrans Engineer Approved Repair Procedure. The deck panel designation numbers are as follows: DP030-001, DP028-001, DP051-001.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the QC MT completed Deck Panel repair. This QA Inspector generated a TL-6028 MT report on this date. The deck panel designation numbers are as follows: DP028-001 and DP051-001.

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.

DP051-001

SFOBB QA VERIFICATION TAG
IN-PROCESS

SUBASSEMBLY DP051-001 Tag No. 0000000006

INSPECTIONS				REPAIRS			
	ZPMC	ABF	CT		ZPMC	ABF	CT
FVT	Chen 6-19	Kevin 6-18	6-18	* CWR			
UT			Log 4-29	HSR			
MT	Shing 6-19	Kevin 6-19	6-19	* NCR			
RT							
Dimen.							

Notes: Initial VT & BF 6/10/08 Li Yanhua 08.06.10 06/19/2008 10:14

Summary of Conversations:

No relevant 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 Ady Velasco, 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer