

**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-003079**Date Inspected:** 04-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2000**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:** Li Xiuyang**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 Panels**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 inspection and in-process grinding of repairs for deck panel Partial Joint Penetration (PJP) welds. The QA Inspector observed ZPMC personnel performing grinding for in process repairs on DP067-001, DP050-001 and DP043-001.

The QA Inspector performed final visual inspection for DP001-001 welds 001 through 006 and DP005-001, welds 001 through 006. While performing this inspection the QA Inspector marked up several areas on both deck panels with apparent discrepancies, along the weld length where repairs were previously attempted. Upon completion of this inspection, DP001-001 & DP005-001 appeared to be non-compliant with the contract specifications

**Summary of Conversations:**

The QA Inspector relayed the above information to ZPMC QC personnel Li Xiuyang and first shift Caltrans QA personnel William Clifford.

**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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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Leach,Ed	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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