

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-003119**Date Inspected:** 14-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shnanghai, China**CWI Name:** Fu Yuong**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 (37ea) deck panels are inside the shop. The QA Inspector in repair process repair work on deck panel DP026-001 and DP028-001.

Magnetic Particle Testing (MT)

The QA Inspector observed ZPMC MT personnel Wang Wei perform final MT after repair work was complete for 15% of the repaired areas on DP032-001. Upon completion of the MT, Mr. Wang Wei stated that the work is acceptable. The QA Inspector performed final MT for approximately 10% of the repaired areas on DP032-001. This inspection covered the repaired areas for the length of weld joint designation 001. The final VT on this deck panel was completed on first shift by ZPMC QC, ABF QC and Caltrans QA personnel Timothy McClendon on 6/14/08. A TL-6028 was generated on this date.

Bay 4

The QA Inspector performed 10% MT after 25% MT acceptance by ZPMC for side panel T-stiffeners on side panel designation SP426A. The QA Inspector performed the inspection for approximately 720 mm on weld joint

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

001 and 002. No relevant indications were noted and a TL-6028 was generated on this date.

Summary of Conversations:

No relevant conversations this date.

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:	Leach,Ed	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
