

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-003136**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 3 – Tower Heavy Machinery Shop

The QA Inspector observed ZPMC qualified welder Dong Yi Qun ID 059450 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP042-001, also grinding was being performed on DP042-001 deck panel repair welds.

The QA Inspector observed four ZPMC personnel performing grinding of deck panel repairs, one welder performing FCAW welding on deck panel for repair of welds, one CWI Inspector, one personnel performing preheat of areas to be welded, and two ABF QC personnel identified as Kevin Chen and Ding Baohua.

The QA Inspector Dixon documented the weld repair areas of deck panel DP026-002 U-Rib weld numbers 1 through 7 and recorded the information on the deck panel repair sheet which is kept in the Caltrans Inspector's office. The documenting was still in progress at the end of the QA Inspector's shift and was continued by Caltrans QA Inspector B75.

The deck panel repair welding in the progress generally appeared to conform to contract specifications.

The QA Inspector located and inventoried the following 31 deck panels in New Tower Building Bay #3 on this

WELDING INSPECTION REPORT

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date: DP026-002,DP067-002,DP055-001,DP052-001,DP003-001,DP042-001,DP038-001,DP077-001,DP028-001, DP065-001,DP015-001,DP074-001,DP025-001,DP020-001,DP030-002,DP042-001,DP040-001,DP006-001, DP051-001,DP050-001,DP049-001,DP078-001,DP075-001,DP080-001,DP027-001,DP070-001,DP072-001, DP031-001,DP018-001,DP030-001, and DP071-001.



Summary of Conversations:

As noted within the report shown above.

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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Dixon,Roscoe

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
