

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-003232**Date Inspected:** 14-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih-Ming/Li Yan Hue	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	OBG side, bottom and deck panels	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC qualified welding personnel FCAW SSD19-PP024-106 and 105 following the guide lines of WPS-B-T-2133. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 25 Amps: 208 - 210 Travel speed: 118 - 120mm/min

Welder ID weld 106: 044795

Welder ID weld 105: 067079

QA observed ZPMC qualified welding personnel FCAW SEG-015B-033 and 034 LD7D to BP-009 OBG section 3BW following the guide lines of WPS-B-T-2132-2. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Volts: 29 Amps: 275 Travel speed: 490mm/min

Welder ID weld 033: 051348

Welder ID weld 034: 201215

QA observed ZPMC personnel fitting floor beam center section @ PP-024 OBG section 4AW. See attached photo.

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.

New deck panel repair area (yard)

QA along with ZPMC QC and ABF QA performed initial Visual Testing inspection (VT) for completed Partial Joint Penetration (PJP) U-rib to deck plate welds on deck panel DP-163-001. All welds that were inspected appeared to exhibit some degree of undercut, lack of fusion, overlap, oversize and/or under fill. All of the (PJP) welds joining U-Rib to deck plate that have inspected on this panel do not appear to comply with the visual acceptance criteria specified in AWS D1.5 2002 and the contract documents and have been marked for repair by ZPMC and ABF QC inspectors.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

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 Patrick Lowry (858)-344-2712, , who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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