

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-003366**Date Inspected:** 21-Jul-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, Cina**CWI Name:** Sun Bo / 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: DP299-001, DP326-002, DP191-001, and DP432-001.

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:

DP405-001, DP460-001, DP108-002, DP005-001, DP191-001, DP432-001,
DP110-002, DP069-001, DP407-001, DP299-001, DP083-001, DP245-001,
DP380-001, DP081-001, DP082-001, DP325-002, DP353-001, DP038-002,
DP108-001, DP044-001, DP486-001, DP042-002, DP564-001.

Visual Testing Before Repair

This QA Inspector performed an initial visual confirmation of the extent of rejectable indications contained in deck panel designated as DP081-001. This visual confirmation was performed in conjunction with ABF

WELDING INSPECTION REPORT

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representative Kevin Chen and ZPMC representative Wang Sei Fa.

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.

Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	DP299-001	345-FCAW-2G(2F)-Repair-1		285	29.1	499	50 Celcius	
2	DP326-002	345-FCAW-2G(2F)-Repair-1		290	29.5	501	50 Celcius	
3	DP191-001	345-FCAW-2G(2F)-Repair-1		285	28.9	498	50 Celcius	
4	DP432-001	435-FCAW-2G(2F)-Repair-1		276	28.2	485	50 Celcius	

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, (381) 694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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