

**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-003379**Date Inspected:** 18-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**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 – Heavy Duty Machinery Shop

The QA Inspector inventoried a total of 18 deck panels stored inside the machine shop for repair.

The QA Inspector did not observe any welding being performed by ZPMC on the deck panels stored inside the machine shop.

The QA Inspector observed the following deck panels were removed from the machine shop and delivered to the assembly shop: DP001-001, DP272-001, and DP488-001.

OBG Bay 1

The QA Inspector observed that DP089-001 had been GMAW tack welded and was idle at Gantry # 1 (SAW) welding had been completed and the panel was idle.

The QA Inspector observed that SAW) welding had been completed and deck panel DP143-001 and DP145-001 were idle at Gantry #2,

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# WELDING INSPECTION REPORT

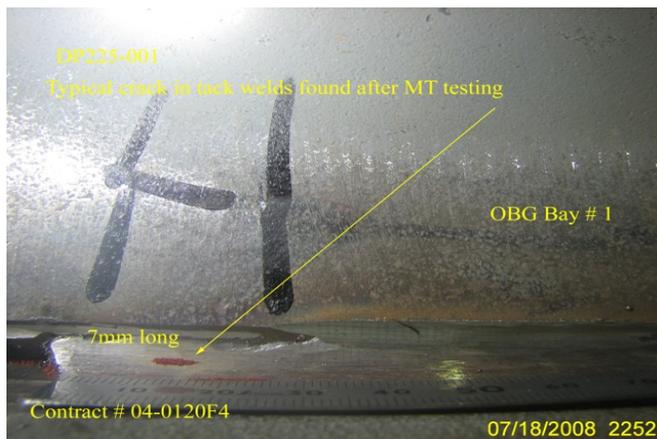
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The QA Inspector observed Mr. Cai Xin Xin of ZPMC performing Magnetic Particle Testing (MT) on deck panel DP225-001, a total of 42 cracks were found during the initial MT testing. The cracks were removed with a grinder and another MT test was performed

The QA Inspector observed ZPMC perform (PMT) weld tests for deck panels DP225-001 and DP089-001, ZPMC found a crack on one of the macro samples and deck panel welding was cancelled for July 19th 08.



### 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.

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<b>Inspected By:</b>	Dixon, Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer

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