

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-003408**Date Inspected:** 07-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

The QA Inspector turned over data analysis for weekly welding reports week 12 for the ABF/Caltrans Partnering Data Analization, Welding Report Date Base – CCO 77 dated May 13, 2008, State Letter No: 05.03.01-0011947 to Jeff Evens of ABF.

OBG Bay 3:

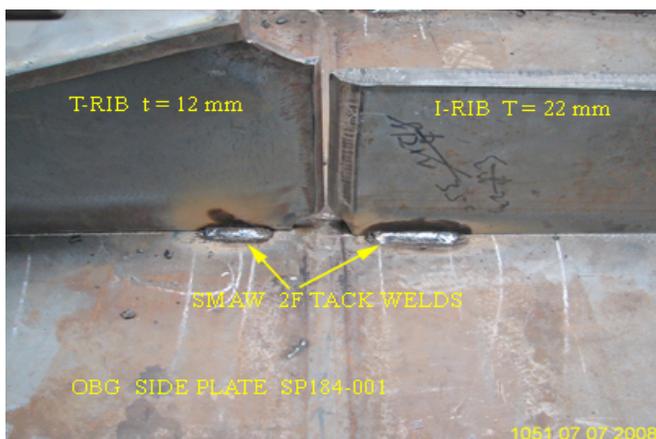
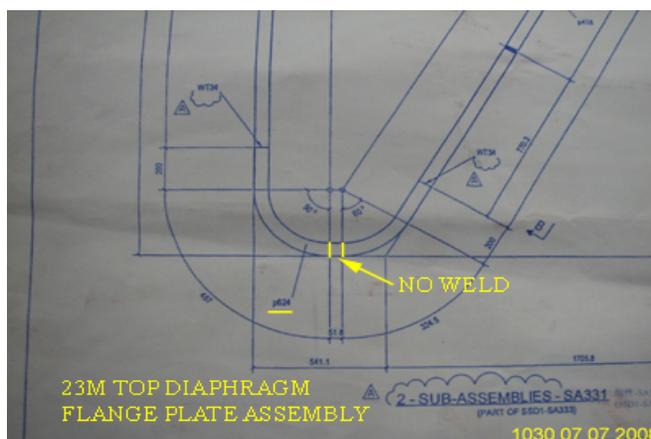
The QA Inspector randomly observed ZPMC welders Wang Zhonghua ID Number 053753 and Feng Changdou ID Number 067572, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2F (Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-P-2112-FCM, to attach T-Ribs and I-Ribs to Side Plate Sub-Assembly SP184-001 at Weld Joint Numbers SP184-001-023 to 028 (I-Ribs) and SP184-001-051 to 054 (T-Ribs). The QA Inspector randomly observed ZPMC CWI Jiang Jian Fei monitoring weld parameters. The QA Inspector also verified the weld parameters at 185 amps for Mr. Wang and 178 amps for Mr. Feng. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC helper utilizing a grinder to prepare the bevels on Diaphragm Flange Plate Assembly SSD1-SA331 piece mark SA331, for fit up into 23M Top Diaphragm SA333(S). The QA Inspector also observed the fit up of Diaphragm flange plate assembly piece marks p667, p1082 and p624. Piece

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mark p624 was not in accordance with the Approved Drawing SSD1-SA331. The drawing shows p624 to be one piece. The fit up p624 is made up of 2 pieces with double "V" weld prep. ZPMC QC informed the QA Inspector that this was an approved "Field Change". The QA Inspector verified the "Field Change" with the Caltrans SMR for the Tower. The attached photographs provide additional detail.



Summary of Conversations:

As noted in the above body of this report.

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 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Franco, Charlie

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer