

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-003451**Date Inspected:** 28-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 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).

Heavy Equipment Shop Bay 3:

The QA Inspector randomly observed ZPMC welder Hu Yongcang ID Number 20805 utilizing the Flux Cored Arc Welding (FCAW) Process in the 2G/2F (Horizontal Groove/Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-345-FCAW-2G(2F)-Repair-1, to perform weld repairs to the welds attaching U-Ribs to Deck Plate Sub-Assembly DP135-001 (DP135-Yellow Tag Number 000261). The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC helper utilizing an angle grinder to prepare the welds attaching U-Ribs to Deck Plate DP378-001 (DP378-Yellow Tag 000259) for weld repair. These areas contain defects and had been previously marked up by ZPMC QC. The attached photograph provides additional detail.

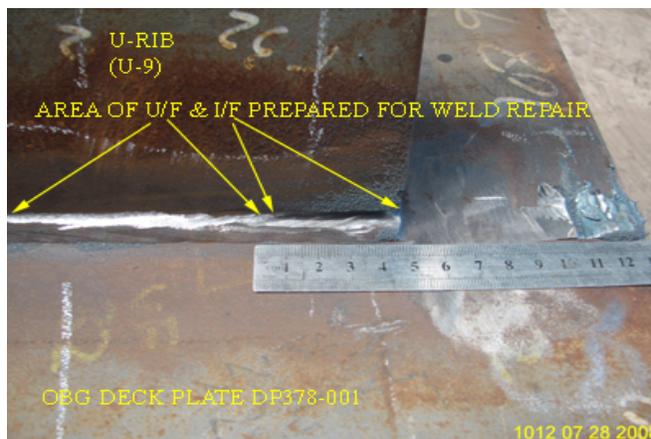
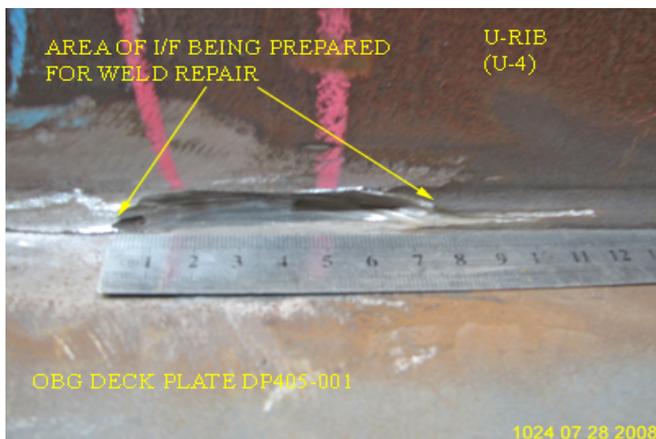
The QA Inspector randomly observed two ZPMC helpers utilizing angle grinders to prepare the welds attaching U-Ribs to Deck Plate DP405-001 (DP405-Yellow Tag 000258) for weld repair. These areas contain defects and had been previously marked up by ZPMC QC. The attached photograph provides additional detail.

The QA Inspector randomly observed three ZPMC helper utilizing angle grinders to blend the welds attaching

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U-Ribs to Deck Plate DP137-001 (DP137-Yellow Tag 000264) after weld repair. These areas contained defects and had been previously marked up by ZPMC QC. The attached photograph provides 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