

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-003612**Date Inspected:** 27-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:** Sun Wei**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:**

Tower Shop Bay 3 Deck Panel repairs

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that twenty-one (21 ea) deck panels are inside the shop. This QA inspector performed a final 3 party inspection with ZPMC and ABF personnel on the following deck panels; DP486-001 and DP353-001. All 3 parties agreed that weld repairs appeared in compliance. This QA inspector also performed initial 3 party VT at the new deck panel repair location identified as deck panel repair area 2 (yard) on the following panels; DP 162-001, DP 189-001 and DP 243-01 all locations were agreed upon for repair for repair by all parties. ZPMC will proceed with repairs. Deck Panel DP 243-001 also had a gouge that was 1 mm in depth that will require ZPMC to repair within the outlines of the repair procedure. The base metal surrounding the gouged area was measured and found to be within the requirements for grinding as long as the contractor did not go below 11.7mm as per ASTM A6. Certified Welding Inspector for ZPMC Sun Wei was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were ABF personnel Kevin Chen, Wang Zhong Yuan and Ding Bao Hua.

Summary of Conversations:

As stated 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, 1-381-694-2685, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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