

**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-003659**Date Inspected:** 15-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** C.M. Chen**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:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

OBG assembly Bay 2

This Caltrans QA Inspector's has been assigned to the ZPMC, ABF, Caltrans group tagging team performing the review of numerous QC and QA documents for the purpose of continuing with the on-going group tagging of the segments identified below.

CT has completed cross checks and is ready for green tagging on the following:

BP57A 5BE  
BP111A 5BE  
SP359A 5BE  
SP332A 5BE  
SP305A 5BE  
BP305A 5CE

Bay 1 Sub Assembly Shop - QA Observations:

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# WELDING INSPECTION REPORT

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1) OBG-Deck Panel Welding-

a) Gantry 1- Caltrans QA Inspector observed ZPMC in the process of welding root pass (GMAW) OBG Deck Panels DP174-001. Caltrans QA Inspector observed ZPMC performing MT inspection on DP255-001. ZPMC MT inspector revealed 0 indications on this 5 rib deck panel. A total of 260 tack welds are incorporated in this deck panel. This QA inspector performed VT verification on 100% of tack welds on this Deck Panel and found one tack weld not ground, three areas of weld splatter in the weld joint needing to be ground, GMAW welding wire protruding from the weld joint, one area that appeared to be a crack like liner indication. This QA inspector performed MT verification on 78 tack welds located at weld joint number 1, 2 and 3. One crack like liner indication was confirmed that was discovered by VT.

b) Gantry 2- This gantry is idle during this shift.

**Summary of Conversations:**

No relevant conversations spoken on this date.

**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.

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| <b>Inspected By:</b> | McClendon, Timothy | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Cuellar, Robert | QA Reviewer |
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