

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-000581**Date Inspected:** 01-Oct-2007**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:	Various	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:	77 & 114 Meter Mock Up	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 77 Skin-A Stiffener weld #2 & 3. Repair welding being performed by qualified welders (A) Yang Lei #040690 and welder (B) Zhai Qingshan #058026. Welding parameters recorded by this QA Inspector were, (A) Amps 225, Volts 27.2, Temperature 185c and Travel Speed 160 mm/min. and (B) Amps 206, Volts 27.5, Temperature 178c and Travel Speed was 190 mm/min. The welders were using welding rods TL 508 which were taken from a hot rod box. The CWI was Ye Yeng Jun and the QC was Chen Tan. Later during the shift the repair welding was completed and is in the process of having the cover ground down and dressed.

Item-2 114 Skin-D, Upper Section, Stiffener MP1004-2, Complete Joint Penetration (CJP) weld #5A is being preheated for the weld repair. The CWI present was Xu Bing.

Item-3 114 Skin-E, Upper Section, Stiffener plate MUSC-MA105-1 to MP1013-1 is being preheated for the weld repair.

Item-4 114 Skin-A Upper section Stiffener MP1001-1(weld 3) & MP1002-4 (weld 4) had a Magnetic Particle test (MT) performed by Zhenhua Port Machinery Company (ZPMC) MT Level II technician Cai Xin Xin and was MT/OK. The Caltrans QA Inspector performed an MT verification on the grind out areas and found them to be in compliance with the project specifications.

Item-5 114 Skin-C Upper section Stiffener MP1003-2 & MP1003-1 grind out areas on welds 10 and 11 were MT tested by ZPMC Level II MT technician Cai Xin Xin MT/OK. The Caltrans QA Inspector performed an MT verification on the grind out areas and found them to be in compliance with the project specifications.

Item-6 114 Skin-E Lower section Stiffener MP1010-2 The grind out area was MT by ZPMC Level II MT technician Cai Xin Xin and was found to be MT/OK. The Caltrans QA Inspector performed an MT verification on

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the grind out area and found it to be in compliance with the project specifications.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
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Reviewed By:	Cochran,Jim	QA Reviewer
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