

**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-004497**Date Inspected:** 31-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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:** deck panels**Summary of Items Observed:**

Sub-assembly – Bay 1 - PMT

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) monitored OBG Production Monitoring Test (PMT) #1 for deck panels DP207-001 and DP234-001 at Gantry #1. The magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC QC/MT Inspector Wang Wei. The visual inspection of tack welds and root gap was performed by ABF QC Lv Yun (ABF), ZPMC CWI Chen Xi (CWI), and QA Inspector. The start time for welding of the PMT was 0029 hours and completion time 0104 hours. QA inspector randomly verified and documented the welding amperage, voltage and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) process, welds 1 thru 6 at the completion of the GMAW root pass and SAW cover pass. The welds were visually inspected by ABF, CWI and QA Inspector. QA inspector witnessed ZPMC UT inspector identified as Tang Xing Shan inspect the welds for depth of penetration and conformance. QA inspector identified designated locations for macroetch sampling per contract requirements. The macroetch specimens were evaluated with a 7X optical comparator and accepted by CWI, ABF, and QA Inspector. All twelve sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 11/1/2008 for additional information.

**Summary of Conversations:**

No significant conversations 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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials

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# WELDING INSPECTION REPORT

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for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer
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