

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-004733**Date Inspected:** 18-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	floor beam, deck panel PMT	

Summary of Items Observed:

Sub-assembly Shop- Bay 4

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed final 100% VT and 10% MT verification of the total linear distance of FB011-013-043B. No apparent indications were observed. QA Inspector notated a QA triangle acceptance mark near the weld joint.

Sub-assembly – Bay 1 - PMT

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) monitored OBG Production Monitoring Test (PMT) #1 for deck panels DP149-001 and DP341-002 at Gantry #1. Prior to PMT #1, the magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Xu Hai (ZPMC MT Inspector). The visual inspection of tack welds and root gap was performed by ABF QC Wang Zhen Hua (ABF), ZPMC CWI Li Yan Hua (CWI), and QA Inspector. The start time for welding of PMT #1 was approximately 0035 hours on Wednesday, 11/19/08. The completion time was approximately 0104 on Wednesday, 11/19/08. The visual inspection of tack welds and root gap of the test panel for PMT #1 was performed by ABF, CWI, and QA Inspector. 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 both the GMAW root pass and SAW cover pass. The welds were visually inspected by ABF, CWI and QA Inspector. QA inspector witnessed ZPMC Ultrasonic Testing (UT) inspector identified as Xue Hairong perform UT on 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 10X optical comparator and accepted by CWI, ABF, and QA Inspector. All fifteen sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 11/19/2008 for additional information.

Summary of Conversations:

No significant conversations 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 Peter Dautermann, 150-0219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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