

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004754**Date Inspected:** 05-Nov-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 Bo			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:	Tower/OBG		

Summary of Items Observed:

89M mock up

Caltrans QA Inspector observed that the weld trial performed on 11-3-08 for the FCAW where numbered backwards by ZPMC. The weldments that were documented for the weld trials by this Caltrans QA inspector as MUB-MA21-A/J- 60 and 29, as detailed in the photograph below during the weld trials on 11-3-08.

Whereas the actual weld numbers are reversed MUB-MA21-A/J-29 (pictured on the left) is actually MUB-MA21-A/J-60 and MUB-MA21-A/J-60 (pictured on the right) is actually MUB-MA21-29. This was noted by this QA inspector after speaking to the ABF representative onsite for the 89M mock up. This QA inspector also informed ZPMC personnel that when they identify the weldments and write them on the components with arrows pointing to the welds to make sure the identity is correct. The Photos below show where ZPMC had written the weld numbers and then crossed them out and re-identified them while this QA Inspector was present.

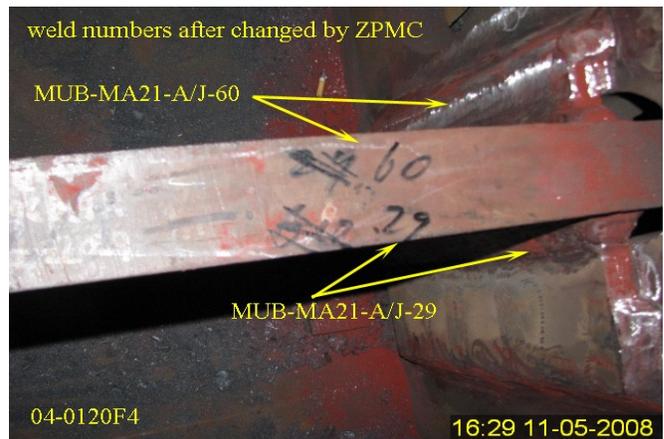
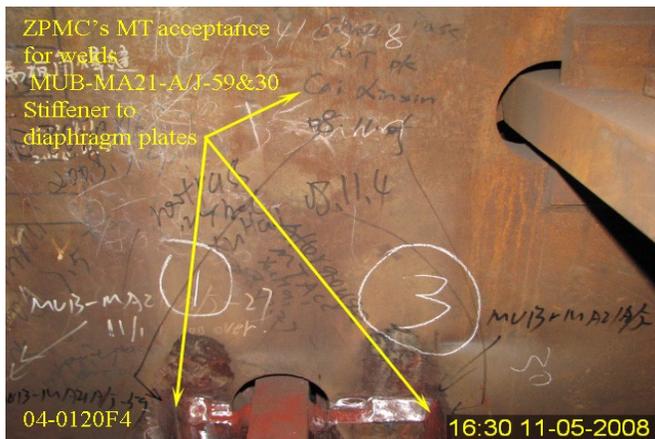
ZPMC performed MT testing on the weld trials for weld numbers MUB-MA21-A/J-59 and 30, ZPMC MT technician hand wrote on the 89M diaphragm "MT cover pass accept 11-5-08". These welds were welded during yesterday's weld trial for the diaphragm to stiffener weld trials. It is the understanding of this QA inspector that ZPMC discovered a linear indication along the weld wrap. This information was relayed from the Caltrans SMR to this Inspector; the ABF and ZPMC personnel did proceed at these locations as they had acceptable results as defined by ABF personnel who showed this QA Inspector his log book which stated MT OK for both welds. This QA Inspector at this time is unsure of the status for these weld trial listed above due to the linear indication reported further information would be needed.

Tower Shop Bay 3

WELDING INSPECTION REPORT

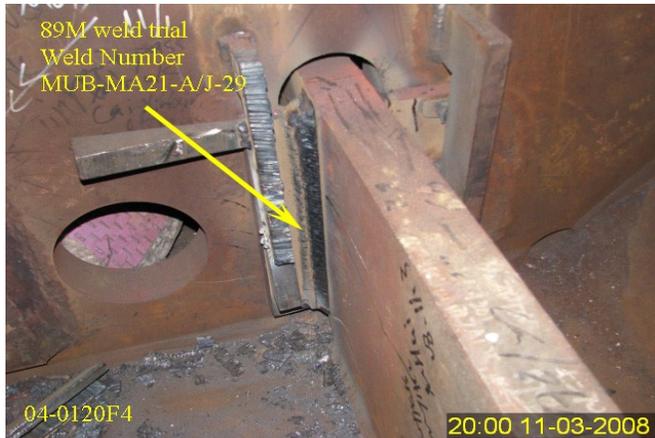
(Continued Page 2 of 3)

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. This QA inspector along with ZPMC and ABF personnel performed the 3 party initial visual inspections. All 3 parties agreed on the areas to be repaired and ZPMC continued working on these locations. The yellow ABF tracking tag affixed to the deck panel was signed by all 3 parties. The deck panels inspected were DP328-002 and DP436-001. This Caltrans QA inspector also performed the final MT verification after ZPMC had performed and accepted theirs. The deck panels where the 10% verification was performed were DP355-001 and DP328-001. At the time of the review the weldments appeared to be within compliance. Certified Welding Inspector for ZPMC Sun Bo 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 Wang Wei.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As noted 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 Josh Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

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