

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007044**Date Inspected:** 23-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / 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:** OBG Components**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Heavy Equipment Shop Bay 11:

ZPMC Representative Li Xiu Yang requested that the QA Inspector perform a Final Visual Inspection (VT) of the stiffener welds on Lift 1 West Tower Skin Plate C at WJ's WSD1-SA77A/E-1A/B through 5A/B and WSD1-SA294A/G-13 through 40 and WSD1-SA294A/G-52 through 61. There appeared to be no indications and the QA Inspector accepted the above listed weld on Lift 1 West Skin Plate C.

OBG Sub-Assembly Bay 12:

The QA Inspector received ZPMC Notification 002056, to perform a Final Magnetic Particle Testing (MT) Verification of the welds on the U-Rib Extensions for Deck Plate DP555-001 at WJ's 043-050, 052-059, 061-068, 070-077 and 079-086. There appeared to be no indications and the QA Inspector accepted the above listed welds on the U-Rib Extensions for Deck Plate DP555-001.

The QA Inspector received ZPMC Notification 002059, to perform a Final "In Process" Visual Inspection (VT) of the welds attaching T=35 mm I-Ribs and the U-Ribs to the base plate on Deck Plate 1AE-DP610-001. There appeared to be no indications and the QA Inspector accepted the welds on Deck Plate 1AE-DP610-001.

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The QA Inspector received ZPMC Notification 002059, to perform a Final “In Process” Visual Inspection (VT) of the welds attaching T=35 mm I-Ribs and the U-Ribs to the base plate on Deck Plate 1AW-DP565-001. There appeared to be no indications and the QA Inspector accepted the welds on Deck Plate 1AW-DP565-001.

The QA Inspector received ZPMC Notification 002059, to perform a Final “In Process” Visual Inspection (VT) of the welds attaching T=35 mm I-Ribs and the U-Ribs to the base plate on Deck Plate 1AW-DP550-001. There appeared to be no indications and the QA Inspector accepted the welds on Deck Plate 1AW-DP550-001.

The QA Inspector randomly observed a ZPMC utilizing the CAAG Process to excavate areas in WJ’s 009, 011 and 013 for R3 repairs in the welds attaching the T=35 mm I-Ribs to the base plate (2G/2F) on Deck Plate 1AW-DP540-001. The area had been marked up by ZPMC Quality Control as rejected from previous Ultrasonic Testing (UT) Examination.

The QA Inspector randomly observed 4 ZPMC helpers utilizing angle grinders to excavate areas in WJ 001 through 008 attaching the U-Ribs to Deck Plate 7BW-DP115-002. These areas had been previously marked up after previous UT Examination.

The QA Inspector randomly observed 1 ZPMC helper utilizing an angle grinder to blend the cover pass on the seam welds attaching U-Rib Extensions to the U-Ribs (2G/2F) and the cover pass on the welds attaching the U-Rib Extensions to the base plate on Deck Plate 1AE-DP595-001.

The QA Inspector randomly observed ZPMC welders Liu Xie ID 066236 and Liu Dai Quan ID 066401, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2G (Horizontal Groove) Position with ZPMC WPS WPS-345-SMAW-2G(2F)Repair-1 to weld R2 repairs to WJ’s 017 and 019 respectively, attaching T=35 mm I-Ribs to the base plate on Deck Plate 1AW-DP555-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
