

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-000073**Date Inspected:** 10-Feb-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Daqirg**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:** Observe Welder qualification testing**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector observed ZPMC perform welder qualification testing. ZPMCs Quality Control (QC) and Moody International supervised and monitored the testing. American Bridge/Fluor (ABF) inspector, Mr. Nate Lindell witnessed the testing. Welders were tested with the flux cored arc welding (FCAW) process, in the 3G position in accordance with welding procedure WPS-B-T-2233-BU2a-F.

Caltrans QA observed the first group of welders that consisted of six welders. The QA observed five of the welders welding outside the travel speed minimum and maximum requirements of the posted Welding Procedure Specification (WPS). The test plates are identified as 070201001, 070201002, 070201003, 070201004 and 070201005. Caltrans QA informed ABF inspector, Mr. Lindell of the welder qualification violation. Mr. Lindell confirmed the findings. Mr. Lindell discussed the welding violation with Moody International representative, Mr. Zhou Daqirg. The welder qualification test plates were completed. Mr. Lindell performed visual inspection of the completed test plates and rejected the test for too wide of weld pass and welding outside welding travel requirements.

WELDING INSPECTION REPORT

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Summary of Conversations:

Mr. Lindell stated that all welder qualification test failed due to welders not welding in accordance with the posted WPS.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
