

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000113
Date Inspected: 03-Apr-2007

Project Name: SAS Superstructure **OSM Arrival Time:** 800
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1730
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhou Raqing	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:	Welder Qualification Observations	

Summary of Items Observed:

Caltrans QA inspector observed welder and welder operator qualification testing being performed at ZPMC testing center. ZPMC Quality Assurance Inspector, Mr. Lu Jian Hua submitted ZPMC welder qualification list, stating the names of the welders and welding processes to be performed 4-3-07 and 4-4-07. American Bridge/Fluor (ABF) representative, Mr. Song Weimin also was present for the welder qualification testing. ZPMC welder qualification list called out five (5) submerged arc welding (SAW) welder operators, thirty-two (32) shield metal arc welding (SMAW) welders and thirty-two (32) flux core arc welding (FCAW) welders for testing. Caltrans QA inspector observed Moody International supervising and monitoring the welder qualification test.



Moody International documenting welders prior to welder qualification testing.

04032007 1028



SAW welder operator welding qualification test plate.

04032007 1354

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(Continued Page 2 of 2)



Summary of Conversations:

Caltrans QA and ABF Inspector, Mr. Song Weimin observed welder, Ms. Huang Congying welding test plate identified as 070403115. The welder was welding in the 3G position, using the FCAW process. Caltrans QA and ABF Inspector observed that the welders travel speed was too slow. ABF inspector informed Moody International Inspector, Mr. Zhou Raqing of the welding violation. Mr. Zhou met with the welder and informed Ms. Huang that she was observed welding outside of the welding procedure specification requirements for welding travel speed. Mr. Zhou then informed Ms Huang that she has failed the welder test and that ZPMC would need to provide more training prior to retesting.

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: McClary, David

QA Reviewer