

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-000121**Date Inspected:** 16-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 Raqi ng	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:	NA	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to welding, testing and fabrication procedures at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

At 1000 hours, Caltrans QA inspectors observed welder and welder operator qualification testing being performed at ZPMC testing center. ZPMC QA Inspector, Mr. Lu Jian Hua was also present. Caltrans QA Inspector observed Moody International supervising and monitoring the testing. Moody International Certified Welding Inspector, Mr. Zhou Raqi ng stated that Moody would be testing twenty-three flux core arc (FCAW) welders and two shield metal arc welding (SMAW) welders in the 3G position. Caltrans QA Inspector observed the seventeen FCAW welders and two SMAW welders. Caltrans QA Inspector, Mr. Alfredo Acuna observed the six FCAW welders. Caltrans QA observed eighteen welders, welding with the FCAW welding process. The welders were observed welding in conformance with posted welding procedure specification (WPS) WPS-B-T-2213-B-U2a requirements. Caltrans QA observed two welders, welding with the SMAW welding process. The welders were observed welding in conformance with posted welding procedure specification (WPS) WPS-B-T-2233-B-U2a-F requirements. However, welders were not cleaning slag at weld terminations during replacement of electrodes while welding continuous weld passes. Caltrans QA notified ZPMC QA Inspector, Mr. Lu of the inspection results.

Caltrans QA observed that no action was taken by ZPMC or Moody to correct weld cleaning prior to resuming the weld pass during the welder qualification testing of the SMAW welders. Caltrans QA observed that Moody International visually inspected the FCAW and SMAW welder qualification test plates. Moody International accepted five FCAW test and rejected twelve. Moody International rejected the two SMAW test. Moody International visual inspection and acceptance/rejection of the test plates appeared to comply with the project

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documents. The identified FCAW and SMAW welder qualification test plates as follows:

FCAW Accepted: #070406024, 070406025, 070406026, 070406027 and 070406031.

FCAW Rejected: #070406017, 070406018, 070406019, 070406020, 070406021, 070406022, 070406023, 070406028, 070406029, 070406030, 070406032 and 070406033.

SMAW Rejected: #070406069 and 070406070.

See Mr. Acuna(s) Caltrans Welding Inspection Report, TL6031, dated April 16, 2007 for additional information.



Summary of Conversations:

As identified within the contents of this report. See Task Leader journal for this week.

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