

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000855**Date Inspected:** 13-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang**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**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Caltrans QA Inspector observed ZPMC welder, Liu Long xian, certification number 044786 depositing filler metal, on a Complete Joint Penetration (CJP) weld number 1, using the Flux Cored Arc Welding (FCAW) process, with the guidelines of Welding Procedure Specification (WPS) WPS-B-T-2231-BU2-P1, on floor beam sections for OBG. The related drawing number is FB003-025-001, and piece numbers include 48C (12mm), 50E (16mm) and 49D (12mm). The QA inspector did not witness the fit up of the three plates, however he did notice plates 48C and 49D, which are 12mm in thickness, were centered on 50E, which is 16mm in thickness. This fit up, by design, has 2mm difference per side between the larger and the smaller plates. The QA Inspector also witnessed ZPMC Certified Welding Inspector (CWI), Li Zhi jiang, monitoring all related welding activities and ZPMC Quality Control (QC) Inspector, Zhu Tiam shu, monitoring and recording related welding parameters. In addition QA inspectors randomly monitored welding activities and also recorded related welding parameters. His findings are as follows, amps 255 to 285, volts 27.4 to 29.5, and a travel speed of 570mm per minute. It appears to this QA inspector all related welding activities comply with applicable codes, standards and specifications.

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Summary of Conversations:

No relevant conversations spoken on this date.

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:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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