

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-002050**Date Inspected:** 22-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

Z. P. M. C. Welders, Du Hong Hua--037779, Shen Yong--0660257, worked on welding the Doubler Plate, to Skin A, of the 89-meter Mock-Up, using Welding Procedure Specification (WPS)-B-T-4312-Tc-P4-2, work is in progress.

114-meter Mock-Up-(lower), Z. P. M. C., Welders, Xu Li Feng--051917, using WPS-B-T-2221-C-U2b-S, no weld numbers present, no interpreter present. The welders are only using approximately one-half of the width of the run off tabs. As a result, the end of the weld bead is concave. By not using all of the available run off tab area, the risk of trapping slag is increased. Where the ends of the individual weld beads are concave, this increases the possibility of cracks occurring, due to uneven cooling.

114-meter Mock-Up-(upper), Z. P. M. C. welders started welding on an upper corner joint, but stopped, because, the weld preheat dropped below the minimum required. Heating pads were placed on the joint, but welding stopped for the day.

Summary of Conversations:

No substantial conversations occurred between the QA Inspector and Z. P. M. C. Quality Control personnel.

Comments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
