

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-001143**Date Inspected:** 01-Jan-2008**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: Zhu Zhonghai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** 77M/89M/114M mockup**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon 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.

Bay 1 - No work.

Bay 2

77 Meter Mockup MUA-MA1 E/F:

QA Inspector Brannon randomly observed ZPMC qualified welder's Mr. Fu Yanjie ID#066268, Mr. Jiang Xiaohu ID#066155, Mr. Guo Dengyun ID#037997, Mr. Liu Shouhai ID#066456, Mr. Xu Wei ID#066253 and Mr. He Shibing ID#066243 groove welding fill passes joining, piece # MUSA-MA5 to MUSA-SA95 weld joints #20, 22, 14B, 13B, 7B & 8B. Mr. Fu, Mr. Jiang, Mr. Guo, Mr. Liu, Mr. Xu and Mr. He was observed welding in the 3G (vertical) position utilizing shield metal arc welding (SMAW) process with a 4.0mm diameter electrode, filler metal brand E7018, class THJ506-Fe-1, manual. QA Inspector Brannon observed the ZPMC QC CWI Inspector Zhu Zhonghai verifying that the welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector observed preheat and welding parameters measured by the QC CWI Inspector Zhu Zhonghai to be: preheat temperature of 110°C and welding parameters amps of 168, 175, 182, 180, 180 & 175 respectively. Welding parameters observed by QA Inspector Brannon appear to be in general compliance with the approved WPS-B-T-4313-TC-P5-1 Rev. 1.

89 Meter Mockup MUSB-MA22:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

QA Inspector Brannon randomly observed ZPMC personnel NDT personnel Mr. Cai Xinxin and Mr. Shou Dongyun performing magnetic particle testing (MT) on welding Joints 13, 14, 15, 16, 17, 18, 19 & 20. Magnetic particle testing not completed at the end of this shift.

114 Meter Mock-Up MUC A58

QA Inspector Brannon randomly observed ZPMC personnel drilling 30mm diameter bolts hole and rimming the bolts holes after drilling.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations to report.

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: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer