

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-001300**Date Inspected:** 13-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xianping**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 Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 3- QA Inspector randomly observed ZPMC qualified welder He Yumei Identification (ID) #048625 utilizing the Flux Core Arc Welding (FCAW) process per the approved Weld Procedure Specification (WPS) WPS-B-T-2132-2 while performing tack welding on Side Plate SP24 weld joints SP024-01-015/016 to plate PL79B. QA Inspector observed ZPMC Quality Control Certified Weld Inspector (QC Inspector) Li Yi Feng monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: welding amperage 285 amps, welding voltage 28 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

Bay 3- QA Inspector randomly observed ZPMC qualified welder Wang Zhonghua ID #053753 utilizing the Shielded Metal Arc (SMAW) process per the approved procedure WPS-B-T-2112-FCM while performing tack welding on Side Plate SP38 weld joints SP038-01-001/002 and SP038-01-003/004 to plate PL88C. QA Inspector observed QC Inspector Xu Xianping monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: welding amperage 185 amps, welding voltage 23 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

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Bay 7- QA Inspector randomly observed ZPMC qualified welder Hu Yacheng ID #049339 utilizing the SMAW process per the approved procedure WPS-B-T-2112 while performing tack welding Stiffeners Piece Mark X3M to FB3 Floor Beam Sub-Assembly Piece Mark X50E at the following weld joints: FB003-15-013, FB003-15-014, FB003-15-025, FB003-15-026, FB003-15-037, FB003-15-038, FB003-15-049, FB003-15-050. The QA Inspector randomly monitored weld parameters and recorded them as follows: preheat temperature 76° Celsius, welding amperage 170 amps. The weld parameters appeared to comply with contract requirements and the approved WPS.

Bay 7- QA Inspector randomly observed ZPMC qualified welder Wang Li ID #044772 utilizing the SMAW process per the approved procedure WPS-B-T-2112 while performing tack welding Stiffeners Piece Mark X3M to FB19 Floor Beam Sub-Assembly Piece Mark X50E at the following weld joints: FB003-19-013, FB003-19-014, FB003-19-025, FB003-19-026, FB003-19-037, FB003-19-038, FB003-19-049, FB003-19-050. The QA Inspector randomly monitored weld parameters and recorded them as follows: preheat temperature 80° Celsius, welding amperage 190 amps. Welding is observed by QC Inspector Xu Xianping. QA observations appear to comply with contract requirements and the approved WPS.

Bay 7- QA Inspector randomly observed ZPMC qualified welder Wang Changfu ID #058102 utilizing the SMAW process per the approved procedure WPS-B-T-2112 while tack welding Bottom Plate Piece Mark X6F to Piece Mark X49D at weld joints FB003-07-004 and FB003-07-005. The QA Inspector randomly monitored weld parameters and recorded them as follows: preheat temperature 49° Celsius, welding amperage 172 amps. Welding is observed by QC Inspector Xu Xianping. QA observations appear to comply with contract requirements and the approved WPS.



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Summary of Conversations:

General communications took place between the QA and QC Inspector.

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:	Quintana,Gabriel	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
