

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-001386**Date Inspected:** 31-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lizhi 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:** Floor Beam**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.

The Caltrans QA Inspector witnessed the preparation for welding by back gouging of a Complete Joint Penetration (CJP) weld 042 by ZPMC personnel, on floor beam assembly's FB013-003, FB013-002, FB013-001, FB004-001, FB004-005, FB004-003, FB004-004.

The Caltrans QA Inspector also witnessed ZPMC welder Chen Chuan Zony certification number 044824 depositing filler metal using the Flux Cored Arc Welding (FCAW) process in the 1G position under the guidelines of WPS -B-T-231-B-U2-F-1 on a CJP butt joint for floor beam assemblies FB004-005, FB004-003, and FB004-004. The Caltrans QA inspector observed ZPMC CWI Lizhi Jiang certification number 07051311 and ZPMC QC Xiang Fegferg monitoring and recording the welding parameters.

The weld parameters recorded for weld number 042 on floor beam FB004-005 were, Amps 284, Volts 29, Temperature 81C and the Travel Speed was measured to be 509mm/min.

The weld parameters recorded for weld number 042 on floor beam FB004-003 were, Amps 279, Volts 29, Temperature 65C and the Travel Speed was measured to be 509mm/min.

The welding parameters recorded by this QA Inspector for weld number FB004-004 were, Amps 284, Volts 29,

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Temperature 80C and the Travel Speed was measured to be 500mm/min.

Summary of Conversations:

No conversations spoken.

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
Reviewed By:	Cuellar, Robert	QA Reviewer
