

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-001542**Date Inspected:** 27-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:****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-up 89m**Summary of Items Observed:**

OBG Bay 1

This Quality Control Inspector observed ZPMC performing Gas Metal Arc Welding (GMAW) process for orthotropic bridge deck number DP-031-001 with Production Monitoring Test plate (PMT) 2-27-08-01 (see digital photo below) The GMAW was performed on the PMT first for the root pass. ZPMC elected to run the welds one rib (2 welds) individually instead of simultaneously as stated in the special provisions (see digital photo below) an incident report will be generated for this process. This QA Inspector recorded all pertinent data associated with the welding (IE amps, volts, travel speed) that was recorded on the PMT inspection sheets. Once the PMT root pass was completed ZPMC proceeded to DP-031-001 for the production welding using GMAW root pass. Two zones were welded, zone A consisted of welds 1&2, 5&6 and 9&10 welded simultaneously. Zone B consisted of welds, 3&4 and 7&8. ZPMC, once the root pass was completed proceeded with the grinding of any irregularities associated with the tack welds that were welded over to bring the profile back into an acceptable range so as when the Submerged Arc Welding (SAW) process is ran the final weld should be with acceptable tolerances with profile size. Later in the shift this QA inspector observed Deck plate DP-018-001 placed at gantry number 1 behind the PMT. A verification of the root gap was performed and discovered that once the deck plate was secured to the reverse camber table that multiple areas were discovered to be great than the .5mm tolerance had allowed. This was brought to the attention of the SMR Ady Velasco by Task Leader Robert Ceullar and was relayed that the allowance was acceptable for the welding process due to being in the camber position. This QA inspector observed ZPMC setting up to weld the PMT with the SAW welding process it was observed by this QA inspector that ZPMC continued the same welding sequence welding one rib at a time as stated above.

WELDING INSPECTION REPORT

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Summary of Conversations:

As Noted in contents above.

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:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Hager, Craig	QA Reviewer
