

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-001552**Date Inspected:** 26-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hu Wei Qing, Huang Wen-Pang			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:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 7 OBG:

The QA Inspector randomly observed ZPMC Welder Wang Liansheng ID Number 051356, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2133 in the 3F (Vertical Fillet) position, to weld various stiffeners to flange piece mark X7M on Floor Beam Sub-Assembly FB008-01. The QA Inspector randomly observed ZPMC CWI Huan Wen-Pang monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 205 amps, 24.8 volts with a travel speed of 116 millimeters per minute. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Welder Wang Qi Zhen ID Number 050356, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2132-3 in the 2F position to tack weld various stiffeners during fit up to Floor Beam Sub-Assembly FB022-01. The QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring weld parameters.

The QA Inspector randomly observed ZPMC Welder Wang Li ID Number 044772, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2132-3 in the 2F position to tack weld various stiffeners during fit up on Floor Beam Sub-Assembly FB022-01. The QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring weld parameters.

WELDING INSPECTION REPORT

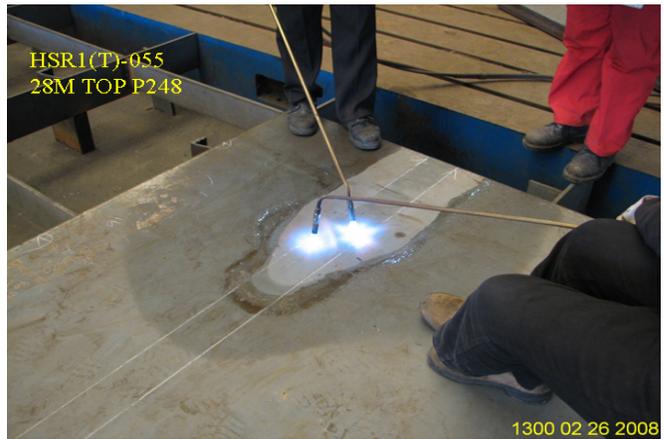
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The QA Inspector randomly observed ZPMC Welder Hong Shuili ID Number 044815, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2132-3 in the 2F (Horizontal Fillet) position, to tack weld various stiffeners during fit up on Floor Beam Sub-Assembly FB021-01. The QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring weld parameters.

The QA Inspector randomly observed a ZPMC Carbon Air Arc Operator, utilizing the Carbon Air Arc Process to back gouge Weld Joint (WJ) FB002-01-045/46 attaching flange X7L to Floor Beam Sub-Assembly FB002-01. The back gouging was being performed on the 045 side.

Bay 8:

The QA Inspector randomly observed ZPMC Personnel performing heat straightening operations per ZPMC HSR1(T)-055 piece mark 28M Top p248(N), HSR1(T)-054 piece mark 28M Top p778(W). The attached photograph provides additional detail.



Summary of Conversations:

There were no relevant conversations.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer