

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-002085**Date Inspected:** 28-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 and Tower**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 Tower and Orthotropic Box Girders (OBG).

New OBG:

The QA Inspector randomly observed ZPMC welder Wang Lan Ying ID Number 045265, utilizing the Submerged Arc Welding (SAW) Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-2221-B-L2c-S-1, to weld the fill pass on Side Plate Section SP022-01 to Side Plate Section SP030-01 at WJ SEG016A-005. The QA Inspector randomly observed ZPMC CWI Chen Chih-Ming monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 638 amps, 33.6 volts with a travel speed of 530 millimeters (mm) per minute. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Wang Ming ID Number 048296, utilizing the SAW Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-2221-B-L2c-S-1, to weld the fill pass on Bottom Plate Section BP008-01 to Bottom Plate Section BP009-01 at WJ SEG015-004. The QA Inspector randomly observed ZPMC CWI Chen Chih-Ming monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 655 amps, 32 volts with a travel speed of 528 mm per minute. Weld parameters appeared to comply with contract requirements.

Bay 8 Tower:

WELDING INSPECTION REPORT

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The QA Inspector randomly observed ZPMC welder Ma Ying ID Number 045270, utilizing the SAW Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-3221-B-U3c-S-1, to weld the fill pass in WJ ESD1-SA226-10A on Tower Diaphragm Sub-Assembly SA226(E) to p407(E). The QA Inspector randomly observed ZPMC CWI Sha Zhi monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Xu Pei Pei ID Number 050323, utilizing the SAW Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-3221-B-U3c-S-1, to weld the fill pass in WJ SSD1-SA293-1A/2A on Tower Diaphragm Sub-Assembly SA293(S) to p559(S). The QA Inspector randomly observed ZPMC CWI Sha Zhi monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 590 amps, 30 volts with a travel speed of 453 mm per minute. The weld parameters appeared to comply with contract requirements. 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: Hager,Craig

QA Reviewer