

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-002217**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai, Xu Le Feng**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:** Caltrans Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

New Tower Bay 2

The Caltrans QA Inspector randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. ESD1-SA77 A/E-43B in the flat groove (1G) welding position. The welding operator was Shen Mei (I. D. No. 041716) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Zhu Zhong Hai (CWI No. 07072101) was present during this welding. The QA Inspector verified the qualifications of the welding operator, and that the electrode/flux classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were as specified on the WPS.

The Caltrans QA Inspector also randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. ESD1-SA233 A/F-21B in the flat groove (1G) welding position. The welding operator was Xia Yong Liu (I. D. No. 048882) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Zhu Zhong Hai (CWI No. 07072101) was present during this welding. The QA Inspector verified the qualifications of the welding operator, and that the electrode/flux classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were as specified on the WPS.

The QA Inspector also randomly observed the Flux Cored Arc Welding (FCAW) of surface buildup in the flat

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

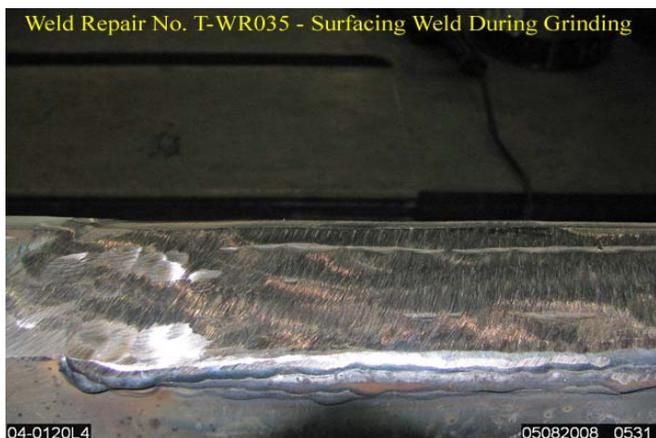
welding position on Skin C shown on Drawing No. P751(W). This work was covered by Weld Repair No. T-WR035. The welder was Zhang Bing Hua (I. D. No. 053316) and the WPS No. was WPS-345-FCAW-1G(1F) Repair. Certified Welding Inspector (CWI), Zhu Zhong Hai (CWI No. 07072101) was present during this welding.

The QA Inspector verified the qualifications of the welder, and that the electrode classification, diameter, amperage, voltage, travel speed, and preheat/interpass temperatures were as specified on the WPS.

New Tower Bay 1

The Caltrans QA Inspector randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. SSD1-SA179 D/E-10B in the flat groove (1G) welding position. The welding operator was Chen Hung Xia (I. D. No. 040460) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Xu Le Feng (CWI No. 07031411) was present during this welding. The QA Inspector verified the qualifications of the welding operator, and that the electrode/flux classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were as specified on the WPS.

All observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

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: Jobs, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer
