

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002312**Date Inspected:** 10-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:	Jiang Jian Fei, Zhu Hong Hai	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 1

The Caltrans QA Inspector randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. ESD1-SA210 J/K-9A by welding operator Xu Yian (I. D. No. 040634); and Weld No. ESD1-SA216J/K-7A by welding operator Shen Mei (I. D. No. 041716). Both welds were made in the flat groove (1G) welding position using Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Jiang Jian Fei (CWI No. 07120691) 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. SSD1-SA173 A/G-15B in the flat groove (1G) welding position. The welding operator was Xu Yen (I. D. No. 052917) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), An Qing Xiang (CWI No. 07120651) 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, and preheat/interpass temperatures were as specified on the WPS. The QA Inspector later observed the SAW of the opposite side of this joint, Weld No. SSD1-SA173 A/G-15A by the same welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

operator, using the same WPS in the same welding position. CWI, Xu Le Feng, was present during this welding.

The Caltrans QA Inspector also randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. SSD1-SA173 B/K-7A in the flat groove (1G) welding position. The welding operator was Yun Chuan Jin (I. D. No. 0503060) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Xu Le Feng 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, and preheat/interpass temperatures were as specified on the WPS.

The QA Inspector also randomly observed the Flux Cored Arc Welding (FCAW) of Weld No. SSP1-SA159G/H-13A. The welder was Tao Qian (I. D. No. 040457) and the WPS No. was WPS-B-T-2231-B-U3-F. Certified Welding Inspector (CWI), An Qing Xiang (CWI No. 07120651) was present during this welding.

New Tower Bay 2

The Caltrans QA Inspector also randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. ESD1-SA216 K/K-5 in the flat groove (1G) welding position. The welding operator was Cao Xiao Hua (I. D. No. 056975) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2312-B-P3-S. Certified Welding Inspector (CWI), Zhu Zhong Hai 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 above 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Jobses, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer