

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-002341**Date Inspected:** 13-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:** Chen Chih-Ming**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 side and bottom panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC assembling scaffolding around floor beam FL-1 and FL-2 on OBG 3BE/pp23.

QA observed two ZPMC qualified welding personnel buttering the edge of BP09-01 where the side panel welds to the bottom panel utilizing the FCAW process and following the guide lines of repair procedure# B-WR337 and WPS-345-FCAW-1G (1F)-REPAIR. According to ABF Quality Control (QC) inspector identified as Li Jing Bo ZPMC intends to build up the edge of this panel by 17mm to compensate for the fact that the panel is too narrow. ZPMC and ABF QC inspectors appeared to be monitoring the welding process continuously. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Welder# 1

Volts: 27 Amps: 271

Welder#2

Volts: 27.4 Amps: 271

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

QA observed ZPMC qualified welding personnel performing FCAW welds on floor beam FL-2-1 wing plate joints SSD15A-PP019-132, SSD15A-PP019-131, SSD15-PP019-133 and SSD15-PP019-132. ZPMC QC inspector appeared to be monitoring the welding process continuously. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 26 Amps: 212



Summary of Conversations:

as noted 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 Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall, Steven	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
