

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-002500**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang SaiFa, Lu Li Qing**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:** Tower/OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

Bay 8

The QA Inspector performed random observations to bay 8 and observed ZPMC personnel in multiple locations performing production work for various tower diaphragm plates that are currently in different stages of production.

The QA Inspector randomly observed in process submerged arc welding (SAW) at one location for internal tower diaphragm plate designation SSD1-SA169A/B-1A, SA169(S) to P659(S). At the time of observation the QA Inspector observed ZPMC welding personnel Xu Pei Pei, welder ID #050323 utilizing the SAW process in the flat (1G) position with LA-85, 4.8mm diameter electrode to weld the complete joint penetration (CJP) weld splice.

The welding was being performed to the requirements of welding procedure specification (WPS)

WPS-B-T-3221-B-U3C-S-1. The QA Inspector observed ZPMC CWI personnel Lu Li Qing monitoring the electrical welding parameters, travel speed and interpass temperature. The work in progress appeared to comply with the noted WPS and the contract specifications.

Bay 7

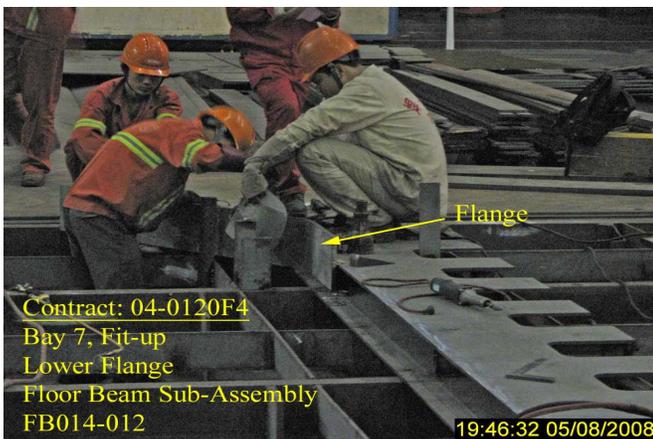
The QA Inspector performed random observations to bay 7 and observed ZPMC personnel in multiple locations performing fit-up, tack welding and production welding on various floor beam sub-assemblies. The QA Inspector observed in-process fillet welding for floor beam sub-assembly FB13A-001-041. The QA Inspector identified the

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welder as Zhang Qing Quan, weld identification 044774. Mr. Zhang Qing Quan was in the process of welding the lower flange to the diaphragm plate with the Flux Cored Arc Welding (FCAW) process with Supercored 71H, 1.4mm diameter electrode. The electrical welding parameters, travel speed and interpass temperature were recorded by ZPMC CWI personnel Wang Sai Fa and the WPS used for this application is WPS-B-T-2133. The welder was observed using proper interpass cleaning methods with a slag hammer and wire brush. The work in progress appeared to comply with the noted WPS and the contract specifications.

Also in bay 7 the QA Inspector observed ZPMC welding personnel Xie Jin Xia utilizing the FCAW process in the flat position with Supercored 71H, 1.4mm diameter electrode to perform tack welding operations for a CJP weld splice on diaphragm plate FB011-001. ZPMC was performing the welding to the requirements of WPS-B-T-2231-B-U2-F-1. The QA Inspector observed ZPMC CWI personnel Li Zhi Jiang monitoring the electrical welding parameters, travel speed and interpass temperature. The welder was observed using proper interpass cleaning methods with a slag hammer and a wire brush. The work in progress appeared to comply with the noted WPS and the contract specifications.



Summary of Conversations:

No relevant conversations this date.

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

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for your project.

Inspected By:	Leach,Ed	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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