

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-003487**Date Inspected:** 19-Jul-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:** Lv 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:** OBG**Summary of Items Observed:****Bay 3**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 3 it was noted that ZPMC was in process for fit-up at multiple stages on side and bottom plates. ZPMC Certified Welding Inspector Wu Ming Kai was present at the time of observation and this QA inspector spoke with Mr. Kai on the work in process for bay 3. It was stated that tack welding for side, bottom and edge plates were in different stages of fit up. Component number BP305-001 8 mm fillet welds using the Flux Cored Arc Welding (FCAW) was observed for the above location being utilized by ZPMC welders on the gantry. Also noted was the CJP weld splice for BP 310-001-043 on stiffener plates under WPS-B-T-2231-B-U3-F-1. The CWI was monitoring the welding parameters and in process welding throughout this bay assisted by ZPMC Quality Control personnel.

Bay 4

During the continued observation by this QA inspector it was noted in bay 4 that ZPMC was welding and fitting interior ring flanges for diaphragm plates. Also observed by this QA inspector was heat straightening process for side plate number SP387-001 under procedure number HSR1(B)-1526 and SP389-001 under procedure number HSR1 (B)-1525 which had a maximum heat input for straightening of 650°C. This process was being monitored and documented by ZPMC Quality Control staff under CWI Lv Li Qing.

Bay 8

This QA inspector continued his observation in bay 8 as ZPMC was using the Flux Cored Arc Welding (FCAW) process on internal diaphragm rings for the butt joint. The component that was observed was number NSD1-SA371-11B. The welding procedure specification noted was WPS-B-T-2233-B-U3_F with welder Jiang

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Yong Sheng. ZPMC CWI Lv Li Qing was observed being present at this location to monitor the welding parameters and progression and assisted by ZPMC Quality Control personnel.

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 Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
