

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-003786**Date Inspected:** 02-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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/T0wer**Summary of Items Observed:**

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

Heavy Duty Tower Shop 1

The QA Inspector randomly observed four qualified welders identified by ZPMC as welder ID # 046345, 066912, 067037 and 066165 welding longitudinal stiffeners to skin plate (B).

The welding was being performed with an Automatic Carriage machine utilizing the flux cored arc welding (FCAW) process with a 1.4mm diameter electrode, filler metal brand Supercored 71H, class E71T-1.

The Partial Joint Penetration (PJP) weld joints were identified as SSD1-SA18 A/E -11/12, and 15/16. The QA Inspector also observed ZPMC qualified welder ID # 048784 performing (FCAW) process welding with a Simi Automatic welding machine at (PJP) weld joint SSD1-SA 18 A/E-25.

Heavy Duty Tower Shop 2

The QA Inspector randomly observed four qualified welders identified by ZPMC as welder ID # 046345, 037705, 066674 and 068864 welding longitudinal stiffeners to skin plate (B4) East. The welding was being performed with a Simi Automatic welding machine at (PJP) weld joints ESD1-SA233 A/F-30/31, and 34/35 utilizing the flux

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cored arc welding (FCAW) process with a 1.4mm diameter electrode, filler metal brand Supercored 71H, class E71T-1.

The QA Inspector observed the ZPMC QC CWI Inspector Jiang Jian Fei monitoring both HD Tower Shop # 1 and 2, along with verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). The welding parameters observed by QA Inspector Dixon appeared to be in general compliance with the approved WPS-B-T-2332-TC-P5-F.

Summary of Conversations:

As noted within the report shown 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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dixon,Roscoe	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
