

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-003810**Date Inspected:** 02-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie and Huang Wen Pang			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 and SAS Tower Fabrication		

Summary of Items Observed:

On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

The QA Inspector has randomly observed the following activities on sub-assembly Bays mentioned below;

Bay 7: OBG - Floor Beam Sub Assembly

The QA Inspector randomly observed ZPMC welder Duan Xiu Zhi ID Number 050502, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld the fill pass on plate splice butt joint of floor beam sub-assembly FB016-023-026. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

This QA randomly observed ZPMC welder Li Xing ID Number 066675, utilizing the FCAW Process with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H in the 1G (Horizontal Groove) Position with ZPMC WPS WPS-B-T-2231-Tc-U2-F-1 to weld CJP root pass on plate splice butt joint (18mm thickness) FB023-004-080. The QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring preheat and weld parameters.

FCAW(2F) fillet welding on stiffener to web plate FB083-002-018/019, tack/fit-up of bent flange to web plate of FB067-001-022 using TL-508 and grinding of gouged CJP weld joint FB003-041 weld joints 044, 032, 020 and 008 in preparation for back welding were all observed in this bay.

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Bay 8: Tower Diaphragm

The QA Inspector randomly observed ZPMC welder Xiao Hexia ID Number 045273, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-3221-B-U3c-S-1, to weld the CJP cover pass on 75mm thick plate splice butt joint of tower diaphragm plate WSD1-SA290 weld joint 13B. This splice happened due to cutting error. QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

The QA Inspector randomly observed ZPMC welder Xie Lian Fang ID Number 045247, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld the CJP fill pass on 14mm thick plate splice butt joint of floor beam FB038-001-078. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

This QA observed three ZPMC welders, ID #048714, ID #045240 and ID #048433 utilizing the FCAW Process in the 2F (Horizontal) Position with a 1.4mm diameter electrode, filler metal brand K-71TSR, semi automatic with ZPMC WPS WPS-B-T-4132 to weld fillet cover pass on fillet weld connection between tower diaphragm plate to diaphragm flange WSD1-SA370-2. The QA Inspector randomly observed ZPMC CWI Liu Hua Jie monitoring weld parameters.

This QA also observed ZPMC welder ID #045240 FCAW(3G) welding CJP fill pass on bottom flange splice butt joint FB061-001-095 utilizing procedure WPS-B-T-2233-B-U2-F. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

Summary of Conversations:

No significant conversation occurred today.

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 Joshua Ishibashi, (858) 232-7081, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Josecito	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
