

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-003887**Date Inspected:** 04-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:	Lvliqing 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 Xin Zhi ID Number 050502 and Huang Xin Lan ID #044780 utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld the cover pass on plate splice butt joint of floor beam sub-assembly FB015-023-026 and FB004-023-020. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

This QA also observed ZPMC welder Wu Haijun ID #201087 using the SMAW process in the 1G (Flat Groove) position with WPS-B-P-2211-B-U2 to weld root pass on plate splice butt joint FB013-018-020. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

FCAW(2G) CJP welding repair on tee joint of CA010-053 and CA010-054 due to UT reject per welding repair report B-WR852 and B-WR853 respectively following procedure WPS-345-FCAW-2G(2F)-FCM-REPAIR. ZPMC welder Hong Shuili ID #044815 was seen performing the repair.

FCAW(2F) fillet welding on stiffener to web plate of floor beam FB088-001-018/019 and

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CSD007-PP036-037/038 utilizing 1.4mm diameter, filler metal brand E71T-1, class Supercored 71H by ZPMC welder Chen Chuanzong ID #044824 and Zhang Qingquan this QA also observed.

Bay 8: Tower Diaphragm

The QA Inspector randomly observed ZPMC welder Xie Lian Feng 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 plate splice butt joint of floor beam FB026-003-001. QA Inspector randomly observed ZPMC CWI Lvliqing 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 fill pass on fillet weld connection between tower diaphragm plate to diaphragm flange NSD1-SA311A/B-9. The QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

Heat straightening was also observed on 75mm plate marked P1524(E) and P1525(E) due to mill induced distortion. Natural gas was used with thermal heat input of less than 600 degree C following procedure HSR1(T)-3769 and HSR1(T)-3777 respectively.

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, Joselito	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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