

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004205**Date Inspected:** 30-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:** Zhang Bao**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 Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Assembly Bay II

Mid bay- QA was tasked with performing welding operation monitoring at locations where diaphragm plates are being joined to deck panels specifically DP001-001, DP002-001 and DP076-001 in the partial joint penetration location which occurs approximately in the bottom 150 millimeters of the joint. QA observed for this operation the FCAW process utilizing 1.4 mm diameter Supercored 71H E71T-1 electrode wire in DCEP mode. Welder He Junrong 201215, a qualified welding operator was observed as well utilizing a stringer bead method for this evolution per the welding procedure specification WPS-B-T-2132 for the 3F fillet weld position. QA measured amperage to be 310 (average), voltage at 30.1 and a travel speed of approximately 270 mm per minute however utilizing a wide stringer bead method which is inside the WPS allowable parameters.

5AW- QA performed/ observed AB/F green tagging with Kevin Dye of components 5AW LD001-003, LD002-003, LD002-004, LD001-004

4BW- QA performed/ observed AB/F green tagging with Kevin Dye of components 4BW LD009-002, LD010-002

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The above mentioned items as observed, corrected by contractor QC & documented by QA appear to conform to the contract documents.

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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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