

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-004667**Date Inspected:** 08-Nov-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:	Geng Wei, Zhang Bao Wei	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:

QA observed the in process joining of Side plate panels SP385-001 to SP386-001 by the SAW process. QA measured welding parameters in accordance with welding procedure specification WPS-B-T-2221-B-L2C-S-2 utilizing 4.0 mm diameter H14 electrode wire by qualified welding operator Wang lanying 045265. Measured amperage at 557.0. Voltage at 30.0, travel speed at 521 mm per minute. ZPMC QC personnel Zhang Bao Lei and Geng Wei was present for this welding evolution.

QA was tasked with performing welding operation monitoring at locations where diaphragm plates are being joined to deck panels specifically DP109-001 and DP244-001 in the complete joint penetration location which occurs approximately in the top 100 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 narrow weave bead method for this evolution per the welding procedure specification WPS-B-T-2233-TC-U4B-F. QA measured amperage to be 300 (average), voltage at 28.5 to 25.5 and a travel speed of approximately 280 mm per minute. ZPMC QC personnel Zhang Bao Lei and Geng Wei was present for this welding evolution.

QA also performed a walkthrough of the entire west segment to ascertain the stages of fabrication development for

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specifically the Deck Panel installation. No joining of deck panels on either segment has been performed in either the deck panel to deck panel, diaphragm plate to diaphragm plate or diaphragm plate to floor beam top flange. This status goes for the east segment as well.

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 Peter Dauterman, who represents the Office of Structural Materials for your project.

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