

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-000983**Date Inspected:** 24-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xianping**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:** Bottom Plate Stiffeners, OGB components**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Bay 2: The QA inspector observed ZPMC personnel cutting of weld tabs from the 77 meter mock up assembly and grinding the cut off areas. The QA inspector also observed the ZPMC workers grinding on the weld access holes and cover passes across the web plates of the assembly.

Bay 3: The QA inspector observed a ZPMC welder using flux cored arc welding (FCAW) on split beam complete joint penetration (CJP) splice welds that will be used for the bottom plate stiffeners for the orthotropic box girder. The QA inspector observed that Quality Control (QC) inspector Xu Xianping, approved C.W.I. monitoring the welding that was being performed by Xin Mong. The welding procedure specification (WPS) being used was WPS-B-T-2233-B-U2-F. The QA inspector made random observations of the welding parameters. The QA inspector randomly observed the welding parameters at approximately 215 amperes, 25 volts and 110cm per minute travel speed. The QA inspector noted that welding is being performed in the vertical (3G) position. At the time of observation, the randomly observed welding parameters appeared to be in general conformance with the contract documents. See the attached photo.

The QA inspector also noted that the sign out form being used for the electrode and flux tracking does not appear to comply with the sample form that is presented in the approved welding quality control plan (WQCP). See the attached photo.

WELDING INSPECTION REPORT

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Form being used for electrode/flux tracking. This form does not look like the sample form provided in the approved WQCP.

日期	产品名称	产品型号	零件代号	物料名称	规格	领用量	物料编号	备注
1								
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12								
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								
焊条 3.2MM	焊条 3.30	焊条	10*355	6*355				
4.0MM	焊条 1.2	焊条	8*355	5*12*355				
5.0MM		焊条	7*355	5*20*355				
发料地点	制单	发料	领料	审核	电脑员			



Summary of Conversations:

The QA inspector Scott Croff had conversations with the ZPMC QC Liaison Fu Guo Gang. The QA inspector was informed of the general status of work being performed by ZPMC. The QA inspector Scott Croff also had a conversation with the QC inspector Xu Xianping. The QA inspector was informed of the welder's name and part numbers that were being welded.

The QA inspector Scott Croff had general conversations with the QA inspector Bruce Berger. The QA inspectors discussed the above mentioned observations in Bay 2, Bay 3 and the electrode/flux storage area. There were no other notable conversations during this shift.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott Quality Assurance Inspector

Reviewed By: Cuellar, Robert QA Reviewer