

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-001005**Date Inspected:** 06-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 7 OBG:

The QA Inspector randomly observed ZPMC welder Hu Ya Cheng ID Number 049339, utilizing the Flux Cored Arc Welding (FCAW) Process with approved ZPMC Weld Procedure Specification (WPS) WPS-B-P-2211-3-U2 to tack weld Floor Beam Web sections X20-X20F (T=12mm A709M-345T2) to X20-X20C (T=12mm A709M-345T2) at Weld Joint (WJ) FB022-01-108. The QA Inspector observed ZPMC CWI Zhang Zhong monitoring weld parameters. Weld parameters appeared to comply with the above approved ZPMC WPS. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC torch cutter utilizing a track mounted torch beveling apparatus, to cut the bevels on Floor Beam Web sections at WJ's FB018-01-108, FB026-01-108, FB021-01-108 and FB021-02-108. The attached photograph provides additional detail.

The QA Inspector randomly observed a ZPMC helper utilizing a grinder to clean the bevel edges after torch cutting on Floor Beam Web sections at WJ's FB018-01-108, FB018-02-108 and FB026-01-108.

The QA Inspector randomly observed a ZPMC helper applying preheat to WJ FB017-02-108 on Floor Beam Web sections X19-X19B to X19-X19A prior to tack welding.

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Summary of Conversations:

The QA Inspector was informed by ZPMC Quality Representative that the tack welding had been discontinued because there was a problem with dimensions on the Floor Beam Web sections, and that it had to be reviewed prior to any more welding being performed on the Floor Beam Web sections.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
