

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-001075**Date Inspected:** 16-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**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:** Tower Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, 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:

CWI Names: Zu Xianping, Wang Nan, Zhu Zhongh

Orthotropic Box Girder (OBG) and Tower Mock Up:

Bay 4:

Quality Control magnetic particle Inspector Mr. Cai Xinxin informed the QA Inspector that he has completed magnetic particle inspection of 10% of the length of each of the stiffener plate welds on bottom plate BP007 /PL38A and all areas that he inspected are acceptable.

The QA Inspector performed random magnetic particle inspections of portions of the stiffener plate welds on bottom plate BP007 /PL38A which had previously been accepted by ZPMC Quality Control. Items observed appear to comply with project specifications. See the photograph below for additional information.

Bay 2:

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The QA Inspector observed ZPMC welder Mr. Fu Yanjie stencil 66268 is using welding procedure WPS-B-T-4312-TC-4P-2 to make shielded metal arc welds on MUB-MA21 weld B/J1. The QA Inspector observed arc E7018 5.0 mm diameter electrodes and a welding current of approximately 200 amps and a minimum base material preheat temperature of 160° C. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Xu Yan stencil 52917 is using welding procedure specification WPS-B-T-2221-C-U2B-S-1 to make submerged arc groove weld on MUSC-MA107. The QA Inspector observed a welding current of approximately 485 amps, 32.2 volts, a travel speed of 430 mm per minute, and the base material had been preheated to a minimum of 160° C. Items observed by the QA Inspector appear to comply with project specifications.



Summary of Conversations:

See above for summary of conversations.

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:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
