

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-001202**Date Inspected:** 09-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hue Wei Qing, Sha Zhi & Wu Meng Kai			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, 77, 89 & 114 Meter Mock-Up		

Summary of Items Observed:

OBG

This Quality Assurance Inspector observed in bay 3 Zhenhua Port Machinery Company Welder Li Meng Qian, welder identification 054460 welding run off tabs on the T-stiffeners for the splice welds between the flanges on side plate SP028-01. The Certified Welding Inspector was Wu Meng Kai. Welder Wang Zhong Hua, welder identification number 053753 was tack welding the knife plates with the shield metal arc welding process for side plate SP004-01. Welder Sun Ti Yu, welder identification was tack welding side plate SP015-01 weld joints 023 & 024. Essential welding variables were checked and found to be as follows; voltage 29.1 and amperage 273. Welder Liu Zi Hong, welder identification 062447 was observed tack welding T-stiffeners to bottom plate BP015-01 weld joints 023 & 024 with the flux core arc welding process. Essential variables were observed and recorded as follows; voltage 28.3 and amperage 275. The gantry was being used to fillet weld the stiffeners to side plate SP017-01 with the flux core arc welding process. The welders performing the welding with the gantry were Li Zhao Qian, welder identification number 048810, Xin Meng, welder identification number 053742 and Li Shu Liang, welder identification number 048801. Essential welding variables were checked for welder Li Zhao Qian on welds 014 & 015 and were as follows; voltage 30.1, amperage 288, preheat 143° Celsius and travel speed 450 millimeter per minute. The Non-Certified Welding Inspector Quality Control helper recording the voltage and amperage was Quo Yang Wei

77 Meter Mock-Up

This Quality Assurance Inspector observed submerged arc welding of MUA-MA1 D/F 16B between by Zhenhua

WELDING INSPECTION REPORT

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Port Machinery Company Welder Xia Yong Liu, welder identification number 048882. The essential welding variables were checked and found to be as follows; voltage 33, amperage 682, preheat 125° Celsius and travel speed 630 millimeters per minute. The Certified Welding Inspector was Zhu Zhong Hai.

89 Meter Mock-Up

This Quality Assurance Inspector observed shield metal arc welding of MUSB-MA22 Skin Plate D weld joints 17 & 18 to the Diaphragm. The two Zhenhua Port Machinery Company Welders were Liang Yan Hai welder identification number 066457 and Xu Cheang Xue, welder identification number 06602. The essential welding variables were checked and found to be as follows; voltage 23.6/24.1, amperage 175/180, preheat 191°/187° Celsius and travel speed 102/105 millimeters per minute. The Certified Welding Inspector was Sha Zhi.

114 Meter Mock-Up

This Quality Assurance Inspector observed flux core arc welding of MUC-107 B/C weld joint 4B by Zhenhua Port Machinery Company Welder Chang Chuancang welder identification number 053870. The essential welding variables were checked and found to be as follows; voltage 36.5, amperage 310, preheat 203° Celsius and travel speed 310 millimeters per minute. The Certified Welding Inspector was Xu Bing.



Summary of Conversations:

No conversations held today.

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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer