

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-001295**Date Inspected:** 14-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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:** Caltrans Mock-Up**Summary of Items Observed:**

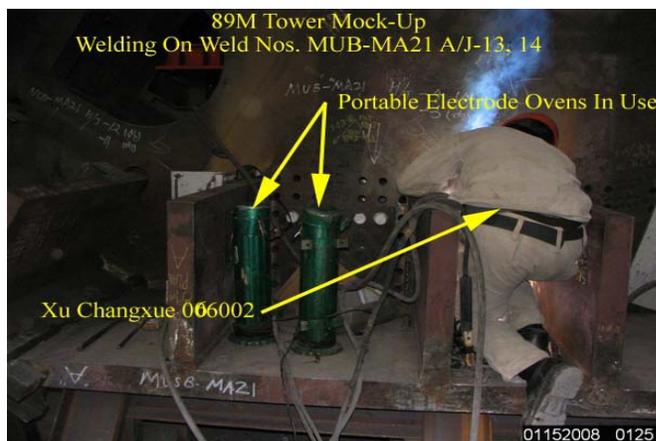
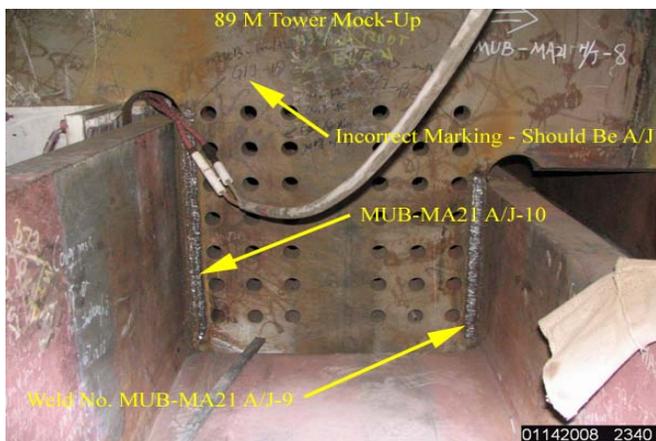
Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

The Caltrans QA Inspector randomly observed three welders welding on Weld Nos. MUB-MA21 A/J-13 and 14; and MUB-MA21 G/J-11, 12, 13, 17 and 18 during the course of the third shift starting on this date. The manual Shielded Metal Arc Welding (SMAW) process was being used and two Welding Procedure Specifications (WPS's) were being used. WPS-B-P-2113 was used for welding ASTM A709M Grade 345 to ASTM A709M Grade 345 using 4.0 mm E7018 electrodes in the vertical fillet (3F) welding position. WPS-B-T-4113-2 was used for welding ASTM A709M Grade 345 to ASTM A709M Grade 485 using 4.0 mm E7018-1 electrodes in the vertical fillet (3F) welding position. The three welders were Xu Changxue (I. D. 066002), Tan Xiaobo (I. D. 066459) and Liang Yanhai (I. D. 066457) All three welders' qualifications for this welding are listed in ZPMC's Master List of Welders/Welding Operators/Tack Welders, Revision 7. ZPMC CWI, Sha Zhi (AWS CWI No. 07081551) was present during this welding. The QA Inspector noted that documentation of preheat/interpass temperature, voltage, amperage and travel speed by the CWI were within the specified ranges of the WPS up until the time of random observation. The QA Inspector also randomly measured the amperage and voltage by use of a calibrated Fluke amp/volt meter. The specified electrodes, E7018 and E7018-1, 4.0 mm diameter, was being used and portable electrode ovens were in use.

All observations appeared to meet the requirements of the job specifications.

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Summary of Conversations:

As identified within the contents of this report.

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.

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Inspected By: Jobses, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer