

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-001360**Date Inspected:** 24-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**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:** 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:** 114 Mock Up & OBG**Summary of Items Observed:**

General

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, Scott Croff and Joe Lanz performing fabrication inspection out on the shop floor today. Mr. Stovall wrote a TL-15 for groove welds being improper on the 77 Meter Mock-Up between two of the skin plates. The measured angle of the fit up was 55°-57° for the OD and 30° for the ID. Angles were supposed to be OD 60° and ID 45°. Mr. Lanz wrote a TL-15 incident report for Zhenhua Port Machinery Companies (ZPMC) failure to flush grind a groove weld where the night before an ultrasonic indication was located and was requested by quality assurance to be flush ground. ZPMC started welding stiffeners to the plate, ignoring the request. Mr. Croff observed tack welding of assorted stiffeners on four different side plates in bay 3 and fillet welding with automated flux core arc welding on several welds on one of the bottom plates.

114 Meter Mock-Up

This Quality Assurance Inspector observed welding by Yun Chuan Jin, welder identification 0503060 on complete joint penetration weld MUC-MA106 B/C-5A. The Certified Welding Inspector, Xu Le Feng for ZMPM was observed checking some of the essential welding variables which were found to be; voltage 32.8, amperage 698, travel speed 620 millimeters per minute and preheat 170° Celsius.

This Quality Assurance Inspector observed welding by Xu Xin Shui, welder identification 040489 on complete joint penetration weld MUC-MA107 B/C-3A. The Certified Welding Inspector, Sha Zhi for ZMPM was observed

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checking some of the essential welding variables which were found to be; voltage 34.2, amperage 712, travel speed 667 millimeters per minute and preheat 154° Celsius.

OBG Production

This Quality Assurance Inspector observed tack welding with shield metal arc welding process by Yang Xuhe, welder identification 057795 on complete joint penetration weld FB014-01-002. The Certified Welding Inspector, Zhang Zhong and the lead Certified Welding Inspector Hu Wei Qing was observed monitoring the welding.

ZPMC Welding Consumables Usage Record with title in English

WELDING CONSUMABLES USAGE RECORD 焊丝使用记录单						
Number 焊丝编号	Welder's Name 使用者姓名	Usage Start Time 开始使用时间	Usage End Time 使用结束时间	Usage Time 用丝时间	Re-Drying Time 再烘干时间	Remarks 备注
1150	Yang Xuhe	17:10				1150 300g
1162	Wang Zhonghua	17:00				1162 300g
1164	Wang Lu	17:00				1164 300g
1166	Han Xiangping					1166 300g

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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