

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-001429**Date Inspected:** 25-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 930**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:	Wu Ming Kai and Cui Yi Ru	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:

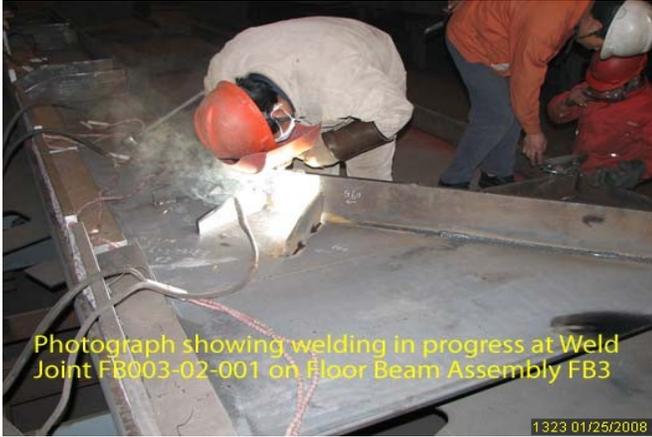
Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 3- QA Inspector randomly observed ZPMC qualified welder Wang Zhonghua ID #053753 utilizing the Shielded Metal Arc (SMAW) process per the approved procedure WPS-B-T-2112 while performing tack welding on Side Plate SP42 weld joints SP042-01-019/020 to plate PL90B QA Inspector observed QC Inspector Wu Ming Kai monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters used and recorded them as the following using 4.0mm diameter electrode: amperage 163 amps, welding voltage 22 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

Bay 7- QA Inspector randomly observed ZPMC qualified welder Wang Changfa ID #058102 utilizing the Shielded Metal Arc Welding (SMAW) process per the approved Welding Procedure Specification (WPS) number WPS-B-T-2112 while tack welding stiffeners to Floor Beam Assembly at weld joints FB003-02-001. The QA Inspector randomly monitored weld parameters and recorded them as follows: welding amperage 160 amps, welding volts 23. Welding is observed by QC Inspector Cui Yi Ru. QA observations and weld parameters appeared to comply with contract requirements and the approved WPS.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Photograph showing welding in progress at Weld Joint FB003-02-001 on Floor Beam Assembly FB3



Photograph showing work in progress on Side Plate SP42

Summary of Conversations:

General communications took place between the QA and QC Inspector.

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:	Quintana, Gabriel	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
