

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-001536**Date Inspected:** 21-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	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 (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

The QA Inspector witnessed ZPMC welder Zhang Qing Quan certification number 044774 depositing filler metal on previously excavated repair area of floor beam number FB007-01 weld number 003 utilizing the Flux Cored Arc Welding (FCAW) process using welding procedure WPS-345-FCAW-2G(2F)Repair. ZPMC Certified Welding Inspector (CWI) Cui Yi Ru Certification Number 00072221 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 295, Volts 29.8, Travel Speed 320mm/minute, temperature 180°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, and appear to comply with approved WPS.

ZPMC was observed preheating and FCAW excavated crack weld areas of FB007-01 Weld number 003. After FCAW post heat was applied for one hour. At the request of the OBG island ASMR, a Caltrans QA Inspector has created an updated tracking log that records the status of the floor beam transverse crack repairs. This tracking log was completed on this date and submitted to the ASMR.

Summary of Conversations:

No relevant conversations spoken on this date.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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