

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-001635**Date Inspected:** 16-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

CWI Inspector: Mr. Sun Wei

Bay 1

The QA inspector along with Caltrans QA Inspector Mr. Larry Viars performed monitoring of the PMT (Preweld Monitoring Test) plate for deck plate DP015. The QA Inspector observed the submerged arc welding passes and the following measurements were obtained: Weld #1 operator Mr. Han Chang Hou, stencil 59460 has a welding current of 670 amps and 26.3 volts, Weld #2 operator Mr. Che Jie, stencil 67468 has a welding current of 670 amps and 26.5 volts, Weld #3 operator Mr. Gao Xin Kong, stencil 59361 has a welding current of 675 amps and 25.5 volts, Weld #4 operator Mr. Hang Ting Guang, stencil 62265 has a welding current of 680 amps and 25.5 volts, Weld #5 operator Mr. Zhou Cheng Shuang, stencil 59400 has a welding current of 675 amps and 24.6 volts, Weld #6 operator Mr. Yuan Fen Chuan, stencil 59355 has a welding current of 680 amps and 25.0 volts.

Following completion of the welding of this PMT plate the QA Inspector performed random visual inspection of the six welds and observed several of the welds appear to have weld overlap at the bottom toes of the welds. See

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the photographs below for additional information. The QA Inspector observed ZPMC QC Ultrasonic Inspector Mr. LiLi Ming performing ultrasonic (UT) inspection of these six PMT welds to determine the amount of weld penetration. Mr. Ming marked all of the welds as being UT acceptable.

The Chinese New Year Holiday started on February 07 and due to this event many of the ZPMC employees are not working.

Inspector did not observe any personnel welding in bay 3.



Summary of Conversations:

See above for summary of conversations.

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: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer
