

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-002039**Date Inspected:** 04-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lei Tao**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 Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77-meter Mock-Up, Z. P. M. C., Welder, He Shibing—066243, using Welding Procedure Specification (WPS)-B-P-2113, Shielded Metal Arc Welding (SMAW) was preparing to weld, by grinding on MUSA-SA104-A/B-(3, 6, & 7), Z. P. M. C., Quality Control (QC) Inspector Lei Tao, was present. Z. P. M. C. Welder Liu Shouhi—066456, was welding on each side of this joint. The QA Inspector checked the welding parameters and measured at various times: 158 amps, 147 amps, 159 amps, and 153 amps, respectively.

89-meter Mock-Up, The QA Inspector asked QC Inspector Lei Tao, why the weld numbers were not present, and was told that the weld numbers were not placed on the Mock-Up, until fit up was complete, even though, the pieces were tacked together, and lifting lugs were being welded onto Skins B, C, & D. Z. P. M. C. Welder Lei Lichao—053619, using WPS-B-T-2233-Tc-U5-F was doing the welding. The QA Inspector checked and measured the welding parameters, at various times, and recorded 147 amps, and 184 amps and 30.1 volts.

114-meter Mock-Up, As Z. P. M. C. personnel were preparing to start welding weld number MUC-MA107-2A & 2B, when the QA Inspector noticed a slag inclusion that was still present from the night before. The QA Inspector pointed this out to the QC Inspector, who had a welder's helper grind it out. A visual inspection was performed to verify the removal of the slag indication. Z. P. M. C. Welder Chang Chuameng—053870, started welding this joint at the end of the shift.

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Summary of Conversations:

Caltrans QA Inspector, spoke with QC Inspector Lei Tao, regarding the placement of weld numbers, and the removal of a previously discovered slag indication.

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:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
