

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-002051**Date Inspected:** 17-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Wu Zhifeng, Xu Xianping**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 Components**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.

Z. P. M. C. Welder-- Wu Xhibin--049804, using Welding Procedure Specification (WPS)-B-T-2221-B-LZX-S-1, welded Complete Joint Penetration (CJP) Welds on Floor Plate (FP)002-01. Z. P. M. C., Quality Control (QC), personnel were monitoring the welding, and WPS parameters, which were recorded as required.

Side Plate (SP)035-01-(001-010), The QA Inspector checked the welding parameters, and measured and recorded--176 amps, 21.8 volts. The QA Inspector asked Z. P. M. C., QC personnel the required WPS, and was initially told WPS-B-T-2132-2-. The QA Inspector was in the process of verifying the information provided, when other QC personnel provided additional WPS information. After determining that the QA Inspector, had initially been given the wrong WPS, the correct one, WPS-B-P-2212-FCAW, was given. During this process, the QA Inspector, asked why the Welder was using electrode--TL-508, when the electrode, specified on the WPS, was THJ-5015-FE-1, Z. P. M. C. personnel, rather quickly realized their mistake / miscommunication. The work had not started at this point, as the Inspector, had been nearby, and saw the Welder approach with his tools. Z. P. M. C., Welder--Wang Jian--067081, began making weld repairs, on the mentioned piece.

Z. P. M. C. personnel are working on SP035-01-(001-010), and Plate 90A, SP041-01-(001-010).

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Summary of Conversations:

The QA Inspector spoke with Z. P. M. C., Certified Welding Inspector Xu Xianping, regarding WPS's, and progress of work.

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
