

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-002188**Date Inspected:** 18-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**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:**

New OBG Bay

This Quality Assurance Inspector (QAI) observed Zhenhua Port Machinery Co. (ZPMC) welder Dan De Yin, welder identification 044759 performing flux cored arc welding (FCAW) on the root of SEG020A-020. This weld was between pieces SP80A and SP68A. Some of the essential welding variables observed were; amperage 272, voltage 29.4, travel speed 502 millimeter per minute and preheat temperature 68° Celsius.

This QAI observed ZPMC welder Liu Xie, welder identification 066236 tack welding SEG018A-0014 between pieces BP17A and BP18A.

This QAI observed ZPMC welder Gao Dong Liang, welder identification 048714 performing submerged arc welding (SAW) between pieces SP62B and SP50B on weld joint SEG019A-027. Essential welding variables observed as follows: amperage 282, voltage 28.5 and preheat temperature 66° Celsius.

This QAI observed ZPMC welder Sun Go Zoo, welder identification 058100 joining pieces SP21A and SP29A with weld joint SEG014A-002. Essential welding variables observed were: amperage 625, voltage 32, travel speed 490 millimeters per minute and preheat 62° Celsius.

This QAI observed ZPMC welder Gao Dong Liang, welder identification 048714 performing FCAW between pieces SP11A and SP19A on weld joint SEG017A-001. Essential welding variables observed as follows: amperage 283, voltage 28.5, travel speed 523 millimeters per minute and preheat temperature 50° Celsius.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QAI also checked on the status of welds which were supposed to have been ultrasonically tested by quality control at 1500 on 04/17/2008. Welds looked at were SEG014A-012, 013, 017, 018, 007 & 006 and SEG016A-001, 002,003, 004, 005 &006. Welds SEG014A-012, 013 & 006 and welds SEG016A-001 through 005 all had ultrasonic defects marked on the plates. Welds SEG014A-017 & 018 were not ultrasonic tested, neither was SEG016A-006. Welds SEG068-01-001 & SEG075-01-001 were actually miss-marked. They were actually SP068-01-001 & SP-75-01-001 which were not ultrasonically tested either.

This QAI reviewed radiographic film for deck panels DP300-001-117, DP273-001-117, DP489-001-117, DP327-001-153, DP275-001-117, DP327-002-153, DP086-001-117 & DP302-001-010 and PQR HP2008041-1 & 2. The Transmittal for the PQR's needs to be corrected as it show deck panels weld numbers instead of the HP numbers.

Summary of Conversations:

No conversations held today.

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:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
