

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-002195**Date Inspected:** 26-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Sun Wei**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:**

This Quality Assurance Inspector (QAI) observed welding on complete joint penetration (CJP) weld DP246-001-189 between plates PL198A & PL198C with the submerged arc welding process (SAW) utilizing welding procedure specification WPS-B-T-2221-B-L2c-S. The Zhenhua Port Machinery Company (ZPMC) welder was Yuan Feng Chuan, welder identification 059355. Some of the essential welding variables which were observed and recorded were; amperage 510, voltage 31.5, travel speed 400 millimeters per minute and preheat temperature 40° Celsius.

This QAI observed ZPMC personnel preparing sites for weld repair of visual welding rejects on deck panel's DP013-001 and DP017-001 by grinding. In a conversation with the ZPMC Certified Welding Inspector (CWI) Sun Wei it was stated that welding should commence sometime this afternoon. The welder Xu Guo yin, welder identification 059443 conducted welding on 4 spots of deck panel weld DP013-001-006 where 2 locations were lack of fusion (LF) and 3 were under fill (UF), 4-UF & 5-UF. Essential variables were not captured.

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Typical weld repair of short visual imperfections (Under Fill UF) on weld joint DP013-001-006.



This is the PJP weld between the closed u-rib and deck panel.

Deck Panel DP013-001 being prepared for weld repair of visual imperfections in Bay 3 of Tower Shop



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: Carreon, Albert

QA Reviewer