

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-002201**Date Inspected:** 21-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Wei/Chen Xi**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:**

DP433-001 & DP486-002

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication. This QA inspector observed ZPMC welding deck plates DP433-001 and DP486-002 at gantry-1 using the Gas Metal Arc Welding (GMAW) and Submerged Arc Welding (SAW) processes. This QA verified the amperages, voltage and travel speed of each of the 6 welding heads used for production under the requirements of WPS-B-T-2342-U1 (U Rib)-3. The Ambient temperature in the shop was recorded at 18°C with the steel temperature at 18°C. The Deck panels were welded in two passes for both processes GMAW process was used for the root pass and SAW process was used for filler and cover pass. During the welding of DP486-002 SAW process ZPMC experienced an equipment malfunction and stopped the welding process. ZPMC ground the start and stop areas on welds 3 and 4 then performed a magnetic particle inspection to ensure weld soundness and continued with the welding process for the SAW welding. It was noted that ZPMC had 2-CWI inspectors; Sun Wei during the day shift hours until 1900 hrs and Chen Xi was the night shift CWI that started at 1900 hours there were 3- ZPMC QC inspectors in bay 1 this date and ABF had 4 QC representatives present this shift for bay 1. By the end of this QA inspectors shift ZPMC had completed the welding for both deck panels. The welding stated above was performed within the requirements of the WPS which included welding parameters and pre-heat and interpass temperatures. The required documentation was turned into and filed in appropriate log books and distributed to the proper personnel.

Summary of Conversations:

WELDING INSPECTION REPORT

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no pertinent conversations 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 Pat Lowry , (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
