

**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-002358**Date Inspected:** 16-May-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:** Changxing Island**CWI Name:** See below**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:** Skin plates**Summary of Items Observed:**

CWI name: Miss. Xie Yan, Mr. Wang Cheng Jun, Mr. Yang Yi Heng, and Mr. Wei Jiam Bo.

"Push down" Heat straightening on skin plate (Tower bay#1 and bay #2) Caltrans Quality Assurance Inspector (QAI) observed few Zhenhua Port Machinery Co (ZPMC) heat straightening operators performed heat straightening with ZPMC Heat Straightening Report (HSR) on plate numbered P58, P633, P89, P313, P1063, P1280, SA17, SA178 and P179. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates have been monitored and recorded and inspected by ZPMC QC within from 0.5mm to 1mm off set (Caltrans requirement Max 3mm) after heat straightening to cooled to ambient temperature. Based on Caltrans QAI observation, no discrepancies were noted.

Submerged Arc Welding (SAW) process on skin plate (Tower bay#1 and bay#2): Caltrans QAI observed four ZPMC welding operators performed semi-automatic SAW on the splice weld of ASTM 709 345 skin plate numbered P86 to P64 with 70mm wall thickness, weld# SSD1-SA178A/D-12B, skin plate numbered P86 to P63 with 70mm wall thickness, weld# SSD1-SA178A/D-11A, skin plate numbered P197 to P211 with 60mm wall thickness, weld# SSD1-SA79D/E-19A, skin plate numbered P26 to SA17 with 45mm wall thickness, weld# SSD1-SA17A/G-16B. The weld designed is a double -V-groove with welding conducted in the in flat position (1G) with proper 4.8mm diameter wire feed electrode JW3 and flux/J1-B, made by China Company and completed with approximate five pass. The parameters used for SAW welding of splice weld was conducted in accordance with Caltrans approved WPS-B-T-2221-B-U3. The semi-automatic SAW was monitored and recorded by ABF Certified Welding Inspector (CWI) Miss. Xie Yan, Mr. Wang Cheng Jun, Mr. Yang Yi Heng, and Mr. Wei Jiam Bo. Based on Caltrans QAI observations, no discrepancies were noted.

Ultrasonic Testing (UT) on repair butt joint weld of skin plate (Tower bay#1): Caltrans QA observed Zhenhua Port Machinery Co (ZPMC) two NDT level II technicians performed angle beam UT on two spots (250mm length) of

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repair butt joint weld on skin plate weld # SSD1-SA17A/G-16B. The metrical of skin plate is ASTM 709 345 wall thickness from 45mm and the test surface has been cleaned. A250mm range reflection has calibrated on "A scan" digital display instrument Parametric model Epoch XT, an angle beam search unit, is an angle wedge 70 degrees applied a source of shear waves, and passes through base weld for the detection of discontinuities. The distance and sensitivity of straight beam and angle beam are calibrated with the International Institute of welding (IIW) ultrasonic reference block. The SWUT test operated and recorded by ZPMC technicians appeared to be in general compliance with requirements of AWS Structural Welding Code D1.5 2002.

### Summary of Conversations:

As Note within the report above.

### 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 Wahbeh Mazen (818)292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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