

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002469**Date Inspected:** 18-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun and 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:** See Below**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenhua Port Machinery Company (ZPMC) on Changxing Island, Shanghai, China for the purpose of monitoring the Quality Control (QC) program during fabrication of the SAS/San Francisco/Oakland Bay Bridge.

Bay 3

The QA Inspector observed ZPMC welding personnel fitting and tacking WT stiffeners on Bottom Plates and Side Plates BP139-001, BP112-001, BP085-001, and SP034-001.

The QA Inspector observed ZPMC welding personnel He Yumei, ID #048625, performing Complete Joint Penetration (CJP) welds on various W21 X 57 splices.

Bay 4

The QA Inspector observed ZPMC are continuing to struggle with maintaining preheat on Internal Tower Diaphragm Plate splice ESD1-SA287-4A. After several hours, Submerged Arc Welding (SAW) was observed using Welding Procedure Specification WPS-T-3221-B-U3c-5-1. The work observed appeared to comply with the contract requirements.

The QA Inspector observed Internal Tower Diaphragm Plate splice SSD1-SA335-1B had been turned over and back gouging had been started using the air carbon arc method.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA Inspector observed ZPMC performing heat straightening on various Internal Tower Diaphragm Plates with QC personnel present and monitoring the temperature.

Bay 7

The QA Inspector observed ZPMC welding personnel Wang Linjiang, ID #051356 and Chen Chuanjong, ID #044824 welding stiffeners and gusset plates on Floor Beam FB003-014.

Bay 8

The QA Inspector observed ZPMC preheat and begin Submerged Arc Welding (SAW) on Internal Tower Diaphragm Plate splice NSD1-SA334-A/B-21. The WPS used was WPS-T-3221-B-U3c-5-1. The QA Inspector observed Certified Welding Inspector (CWI) Xu Bing monitoring the welding. The work observed appeared to comply with the contract requirements.

Summary of Conversations:

The QA Inspector had ongoing conversations with ABF C. K. Chen and other ABF QC personnel regarding the problems ZPMC is having with preheat on the Internal Tower Diaphragm Plate splice welds.

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:	Hager,Craig	QA Reviewer
