

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-002735**Date Inspected:** 26-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:** Shanghai, China**CWI Name:** Zhang Bao Lei, Wu Zhi Feng**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 & Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) Bruce Berger arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QAI observed and/or discovered the following.

Bay 2

No work observed

Bay 3

This QAI observed ZPMC personnel cutting SP412-001 Side Plate Webs in shop and tack welding Bottom Plate BP059-001 T-stiffeners and Side Plate SP090-001 webs in place.

This QAI observed ZPMC welder Du Henghua, welder identification 037779 tack welding Bottom Panel welds BP059-001-066 & 066 and Xhang Feng, welder Identification 049769 tack welding welds BP086-001-064 & 065. Tack welds of webs were also being carried out on Side Panel SP090-001 by welder Wang Zhong Hua, welder identification 053753.

This QAI observed ZPMC welder Wu Xhibin, welder identification number 049804 welding End Plate complete joint penetration (CJP) welds EP024-001-001 & EP028-001-001. Essential variables were observed and noted below.

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Welding Bottom Plate T-stiffener welds BP113-001-56, 57, 60, 61, 64 & 65 on gantry 1 was also observed by this QAI. ZPMC welders were Li Shu Liang, welder identification 048861, Liu Zi Hong, welder identification 062447 and Sun Ti Xu, welder identification 054459. Essential welding variables observed are recorded below.

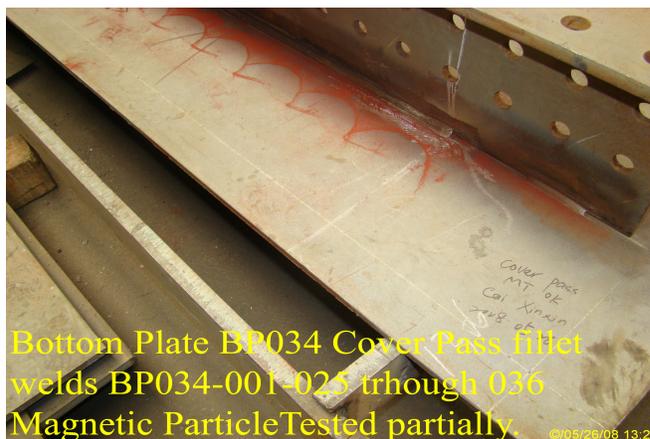
This QAI observed ZPMC Magnetic Particle Testing Technician Cai Xinxin testing three selected areas on each of Bottom Plate Fillet welds BP034-001-025 through BP034-001-036. All areas of welds tested by ZPMC were marked acceptable as they appeared to be in compliance with the code and specifications.

Bay 4

This QAI observed welding of Side Panel SP528-001-050 & 051 T-stiffener welds; and CPJ welds for SSD1-SA27 A/B 2A- 43m Diaphragm Sub-Assembly (Top Assembly); SSD1-SA285 – 43m BTM Diaphragm Flg Plate Sub-Assembly & ESD1-SA287- 23 m Diaphragm Sub –Assembly (Btm Pl). ZPMC welders Li Meng Qian, welder identification 054460, Li Shi Qiang, welder identification 053609 and Li Zhao Qian welder identification 048810 were the welders. Some of the essential welding variables were observed and are recorded below.

Also observed by the QAI was the welding of NSD2-SA333 A/B – 23m Diaphragm Sub-Assembly weld by ZPMC welder Jian Jingteng, welder identification 046830. Essential welding variables observed are recorded below.

This QAI also observed ZPMC personnel heat straightening Side Panel SP336-001 & Bottom Panel BP142 (A)-001 and back gouging of a CJP weld on the SA333 Diaphragm.



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	NSD1-SA333A/B	WPS-B-T-3221-B-U	Xie Yong Jun	615	30.5	490mm/min	200C	N/A
2	EP024-001-001	WPS-B-T-2221-B-L	Xu Ming Kat	508	30.7	446mm/min	105C	N/A
3	SSD1-SA27A/B 2A	WPS-B-T-2233-B-U	Zhao Chen Sun	218	26.5	118mm/min	100C	N/A
4	BP113-001-056	WPS-B-T-2132-3	Zhang Bao Lei	303	30.8	446mm/min	77C	N/A
5	ESD1-SA287-7B	WPS-B-T-2233-B-U	Zhao Chen Sun	218	26.8	115mm/min	100C	N/A

Summary of Conversations:

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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:	Cochran, Jim	QA Reviewer
