

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-002741**Date Inspected:** 27-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** 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:** Tower / OBG**Summary of Items Observed:**

Bay 3

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication. During his observations it was noted that ZPMC was working on the fit-up process for components SP33-001 and SP362-001 using tack welds to fit the WT stiffeners to the flat plates. Also being welded in this bay was SP605-001 ZPMC was using the gantry in this bay to apply the 6mm fillet welds under WPS-B-T-2132-3. Pre-heat and welding parameters were being monitored by ZPMC Certified Welding Inspector Wu Ming Kai along with the general progression of the welding.

Bay 4

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication and observed ZPMC welding in bay 4 where ZPMC CWI Sha Zhi was observed monitoring the welding of diaphragm plate splices using the Submerged Arc Welding (SAW) process for component number ESD1-SA238 3 and 4-B. During this QA inspectors observation it was noted that ZPMC was using WPS-B-T-2221-B-U3c-S-1 with welding operator Jiang Jingteng (046830) performing the SAW welding process for this location. ZPMC and this QA inspector verified the welding parameters as being within the tolerances of the above noted WPS along with preheat and interpass temperatures. ZPMC was using thermal heating blankets for preheat and interpass temperatures and appeared to be within the tolerances of the above noted WPS.

Bay 7

During this QA inspector continued observation at ZPMC it was noted that in bay 7 ZPMC personnel was performing the fit-up on floor beam FB013-008 flange to web plate. ZPMC welder Ren Jin Zhu was observed as using the Shielded Metal Arc Welding (SMAW) process under WPS-B-P-2112. Pre-heat and interpass temperatures were being monitored by CWI Huang Wen-Pang and appeared to be within the tolerances of the

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above noted WPS. Also being fit-up in this bay was FB003-031 with welder Yang Gen Cheng that was also fitting flange to web plate. The WPS and welding process being used was the same as noted above. All work being performed in this bay was being monitored by ZPMC CWI Huang Wen-Pang and appeared to be within the general requirements on the contract documents.

Summary of Conversations:

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

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