

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-002882**Date Inspected:** 05-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**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:** Tower & OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 1:

The QA Inspector performed a random 10% Magnetic Particle (MT) Inspection of Tower Skin Plate C WJ SSD1-SA17A/G-26B. There appeared to be no indications and the QA Inspector accepted WJ SSD1-17A/G-26B.

The QA Inspector randomly observed ZPMC welder Yun Chuan Jin ID Number 0503060, utilizing the Submerged Arc Welding (SAW) Process in the 1G Position (Flat Groove) with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2221-B-U3c-S, to weld the fill pass in WJ SSD1-SA179D/E-13B(CJP), 7(PJP) and 24B(CJP) on Tower Skin Plate C Sub-Assembly SA179(S). The QA Inspector randomly observed ZPMC CWI Xu Le Feng monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 658 amps, 32.1 volts with a travel speed of 565 millimeters (mm) per minute. The weld parameters appeared to comply with contract requirements. The attached photographs provide additional detail.

The QA Inspector randomly observed ZPMC welder Shen Mei ID Number 041716, utilizing the SAW Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-2221-B-U3c-S, to weld the fill and cover pass in WJ ESD1-SA77D/E-20B(CJP), 7(PJP) and 11B(CJP) Tower Skin Plate C Sub-Assembly SA77(S). The QA Inspector randomly observed ZPMC CWI Xu Le Feng monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 650 amps, 33.2 volts with a travel speed of 605 mm per

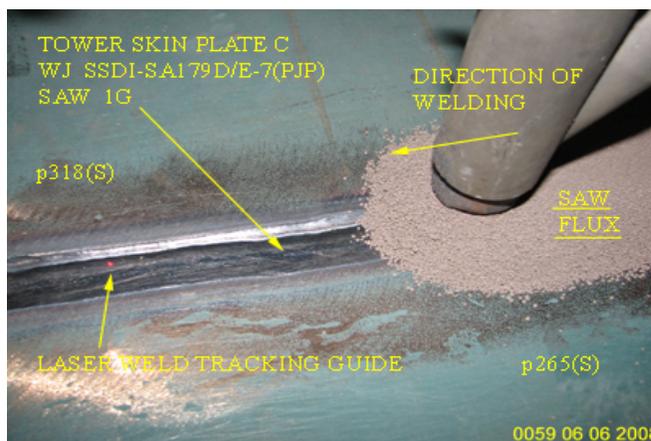
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minute. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

OBG Bay 7:

The QA Inspector located Floor Beam Diaphragms FB016-006 and FB016-013 for the purpose of performing final MT after weld repairs and ZPMC QC final MT. According to the ZPMC "Notification of Witness Inspection" sheet, ZPMC QC had performed their final MT at 09:15 for FB016-013 and 09:25 for FB016-006. The ZPMC QC final MT had been performed on the near side of both FB016-006 and FB016-013. Both FB016-006 and FB016-013 had been flipped over to the far side and the near sides of both Floor Beam Diaphragms are inaccessible.



Summary of Conversations:

There were no relevant conversations.

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.

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Inspected By:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Cochran,Jim	QA Reviewer
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