

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-003044**Date Inspected:** 23-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Xu La Fong**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 components**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

This Inspector performed in-process welding inspection on the submerged arc welding (SAW) process on tower skin plate NSDI SA33 A/F-24A weld splice in Tower shop Bays# 1. This Inspector randomly observed the ZPMC QC/CWI Mr. Xu La Fong (Bay 1) along with three CAWI monitoring welding voltage, pre-heat & interpass temperatures & cleaning, weld pass width, profile/size and travel speed per the approved WPS-B-T-3221-B-U3c-S-1.

Per ZPMC UT inspection notification (000573) this inspector performed Ultrasonic Testing (UT) verification of the QC UT Inspected and accepted welds. QA Inspector's visual and UT verification appears to be acceptable with AWS D1.5-02 section 6, table 6.3. Reference QA Ultrasonic Test Report TL-6027 dated 6/23/08 for specific test data.

Per ZPMC MT inspection notification (000573) this Inspector performed Magnetic Particle Testing (MT) verification of the QC MT Inspected and accepted welds. QA Inspector's MT verification appears to be acceptable with AWS D1.5-02 section 6.26.2.1 & 6.26.2.3 Reference QA Magnetic Particle Test Report TL-6028 dated 6-23-08 for specific test data.

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The in-process welding, fit-up & joint preparation observed by this Inspector appears to comply with the previously mentioned WPS in this report, the approved drawings, the WQCP, Contract Special Provisions and AWS welding code D1.5 (2002).

No other observation took place during the shift by this inspector.



Item	Description	WBS	Dwg No.	Status
1	Picture upper left SAW process on weld NSDI SA33A/F-24 A/B			
2	Picture upper right UT on various welds for skin plate SA179.			

Summary of Conversations:

None noted.

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:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
