

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-003188**Date Inspected:** 24-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:** Jiang Jian Fei**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**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 2:

The QA Inspector randomly observed ZPMC welder Yang Meizhen ID Number 042195, 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 ESD1-SA216F/K-10B on Tower Skin Plate E Sub-Assembly SA216(E). The QA Inspector randomly observed ZPMC CWI Jiang Jian Fei monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 640 amps, 32.7 volts with a travel speed of 620 millimeters (mm) per minute. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

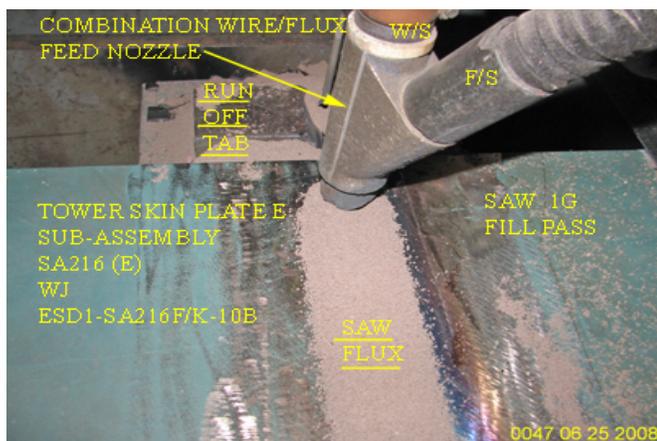
The QA Inspector randomly observed ZPMC welder Xue Yian ID Number 040364, utilizing the SAW Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-T-2221-B-U3c-S to weld the cover pass in WJ ESD1-SA216A/K-19B and 20B on Tower Skin Plate E Sub-Assembly SA216(E). The QA Inspector randomly observed ZPMC CWI Jiang Jian Fei monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 668 amps, 32.1 volts with a travel speed of 635 mm per minute. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

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The QA Inspector randomly observed a ZPMC CNC Torch Cutting Operator trimming the edge and cutting the slots for Skin PLate E Longitudinal Stiffeners in 23M Tower Diaphragm SA333. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Liu Wei ID Number 048532, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 1G Position (Flat Groove) with ZPMC WPS WPS-B-P-2211-TC-U4b to attach the Run/On and Run/Off Tabs to Tower Skin Plate E Sub-Assembly SA227(E) Longitudinal Stiffener splice WJ ESD1-SA227A/H-55A. The QA Inspector randomly observed ZPMC CWI Jiang Jian Fei monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.



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 Josh Ishibashi, 13764716411, who represents the Office of Structural Materials for your project.

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Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
