

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-003353**Date Inspected:** 09-Jul-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:** Chen Chih Ming**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 Assembly**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Robert H. Vatcher, 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 QA Inspector observed and/or discovered the following.

QA Inspector Robert Vatcher, was assigned to perform monitoring of the Orthotropic Bridge Girder (OBG) Assembly facility located on the southwest portion of the Changxing Island. The following items were observed;

QA observed that fixture rigging continues from previous days to facilitate further segments into place and assembling.

4BE- QA performed Welding Procedure Specification (WPS) measurements on piecemarks FB26B to SP44B, SP56B, SP80B & SP68B for welding compliance. The following measurements/ readings were observed. Preheat measured at 60 degrees Celsius, amperage at 210, voltage at 26.0 at a travel speed of 140 millimeters per minute performed by qualified SMAW welder Xu Li Quang. The above mentioned item, as compared against WPS-B-P-2214-TC-U4B-FCM appears to be in conformance with the contract documents.

4BE- As well QA performed Welding Procedure Specification (WPS) measurements on piecemarks FB26A to SP44A, SP56A, SP80A & SP68A for welding compliance. The following measurements/ readings were observed. Preheat measured at 60 degrees Celsius, amperage at 200, voltage at 27.0 at a travel speed of 134 millimeters per minute performed by qualified SMAW welder Ren Jinzho. The above mentioned item, as compared against WPS-B-P-2214-TC-U4B-FCM appears to be in conformance with the contract documents.

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Summary of Conversations:

No relevant conversations this date.

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 Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
