

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-003426**Date Inspected:** 28-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo, Xu Le feng**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, Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

Tower Heavy Machinery Shop Bay 1

The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of the root pass and fill passes on Weld No. NSD1-SA76A/H-59B, by welding operator, Chen Hong xia (I. D. No. 042460), using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S-2. The welding was being done in the flat groove (1G) welding position. Certified Welding Inspector (CWI), Xu Le Feng (CWI No. 07031411) was present during this welding as was ABF QA Inspector Liu Cheng. The QA Inspector verified the qualifications of the welding operator and that the electrode classification and diameter, voltage, amperage, and travel speed were within the ranges specified on the WPS. The minimum preheat of 65° Celsius for 60 mm thickness was also verified.

OBG Sub-Assembly Shop – Bay 1

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, was present to monitor activities associated with the Production Monitoring Test (PMT) of Orthotropic Box Girder (OBG) Deck Panel U-rib welds. The PMT representing Deck Panels DP588-001 and DP603-001 was monitored. After MT of the tack welds was accepted by ZPMC Level II MT Technician, Cai Xin Xin, the three ribs (six welds) were simultaneously welded to the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

simulated deck plate in the horizontal groove (2G) welding position. The Welding Procedure Specification (WPS) used was WPS-B-T-2342-U1(Urib)-4. It is a combination procedure using gas metal arc welding (GMAW) for the root pass and submerged arc welding (SAW) for the cover or fill pass. The filler metals being used were verified to be as specified on the WPS; 1.4 mm diameter, ER70S-6 (JM-56) for GMAW and 4.8 mm diameter EH14K (H14) for SAW. During the test, the Caltrans QA Inspector recorded the parameters of amperage, voltage, and travel speed on the U-Ribs PMT Inspection Sheet, dated 07-29-08, for both welding processes. The name of the gantry operator and each of the six welding operators' identification numbers were also recorded on the U-Ribs PMT Inspection Sheet. ZPMC Certified Welding Inspector (CWI), Sun Bo (08021741) and ABF QA Inspector Whang Zhen Hua were present during welding.

The final weld was visually examined and accepted by ZPMC CWI, Sun Bo; and ABF QA Inspector Whang Zhen Hua. All welds appeared to meet the specified visual examination acceptance criteria.. After ultrasonic examination (UT) and acceptance by ZPMC Level II UT Technician, Ma Ji Long, the Caltrans QA Inspector designated the locations for the fifteen required macro-etch specimens. All macro-etch specimens were prepared and found acceptable by the ZPMC CWI, and the ABF QA Inspector. The macro-etch specimens were then examined by the Caltrans QA Inspector and the depth of penetration on each measured and the results recorded on Caltrans Project 04-0120F4 SAS OBG Fabrication Macro Etch Log.

All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

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 (13816942685) China, who represents the Office of Structural Materials for your project.

Inspected By: Jobses, Kenneth

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer