

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-003446**Date Inspected:** 15-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Sun Wei, Huang Wen Pang	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	

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).

OBG Bay 1:

The QA Inspector randomly observed ZPMC welders Zhang Shao Hui ID Number 059403, Chen Jie ID Number 059468, Xiang Huan Feng ID Number 059416 and Feng Chuan Hong ID Number 059371, utilizing gantry mounted welding apparatus with the Gas Metal Arc Welding (GMAW) Process in the 2G (Horizontal Groove) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2342-U1(U-Rib)-3, to weld the root pass of the U-Ribs to Deck Plate Sub-Assembly DP495-001 at Weld Joint (WJ) Numbers DP495-001-001/002(U-252) and 005/006(U-180). The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 377/367 amps, 30.1/30.4 volts (WJ 001/002) for Mr. Zhang/Mr. Chen and 378/380 amps, 29.8/30.4 volts (WJ's 005/006) for Mr. Xiang/Mr. Feng with a travel speed of 535 millimeters (mm) per minute for all welders. The weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welders Zhang Shao Hui ID Number 059403, Chen Jie ID Number 059468, Xiang Huan Feng ID Number 059416 and Feng Chuan Hong ID Number 059371, utilizing gantry mounted welding apparatus with the Gas Metal Arc Welding (GMAW) Process in the 2G (Horizontal Groove) Position with ZPMC WPS WPS-B-T-2342-U1(U-Rib)-3, to weld the root pass of the U-Ribs to Deck Plate Sub-Assembly DP306-001 at WJ Numbers DP306-001-001/002(U-175) and 005/006(U-261). The QA Inspector

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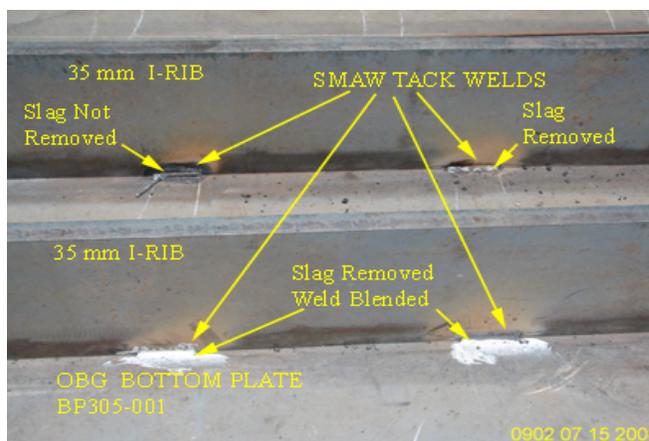
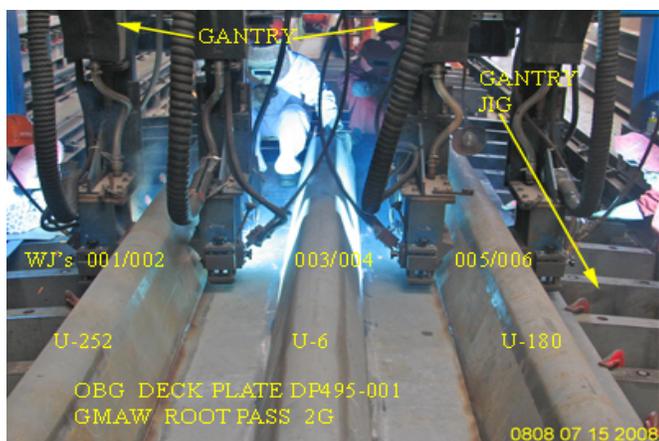
randomly observed ZPMC QC monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 375/371 amps, 30.5/30.4 volts (WJ 001/002) for Mr. Zhang/Mr Chen and 370/367 amps, 30.3/30.2 volts (WJ's 005/006) for Mr. Xiang/Mr. Feng with a travel speed of 534 mm per minute for all welders. The weld parameters appeared to comply with contract requirements.

OBG Bay 3:

The QA Inspector randomly observed ZPMC welder Wang Zhonghua ID Number 053753 utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2F (Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2132-3, to weld 35 millimeter (mm) I-Ribs to Bottom Plate Sub-Assembly BP308-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Hai Xia Feng ID Number 054467, utilizing the SMAW Process in the 2F (Horizontal Fillet) Position with ZPMC WPS WPS-B-T-2132-3, to weld 35 mm I-Ribs to Bottom Plate Sub-Assembly BP305-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Hai Xia Feng ID Number 054467, utilizing the SMAW Process in the 2F (Horizontal Fillet) Position with ZPMC WPS WPS-B-T-2132-3, to weld 22 mm I-Ribs to Side Plate Sub-Assembly SP652-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The weld parameters appeared to comply with contract requirements.



Summary of Conversations:

As noted in the above body 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, who represents the Office of Structural Materials for

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your project.

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