

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-003488**Date Inspected:** 23-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Zhu Zhong Hai**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:**

89m mock up

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observations of the Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector observation of the 89m partial mock up under Submittal SUB101R2 it was noted that ZPMC had fit up the lug plate to stiffener and diaphragm plate. ZPMC had begun and performed the welding prior to Caltrans QA inspector arriving onsite for observation. Once this QA inspector was onsite it was noted that two (2) welders were working simultaneously on welds, MUB-MA21-A/J-12 welder Dai Lu under WPS-B-T-4313-P4-1 with the Shielded Metal Arc Welding (SMAW) process for the lug plate to diaphragm. On the opposite side of the 89m mock up was weld joint MUB-MA21-G/J-11 welder Li Meng Qian under WPS-B-T-2333-TC-P4-F with the Flux Cored Arc Welding (FCAW) process for the lug plate to stiffener. Once the welds were completed the controlled cool down was started. Weld number, MUB-MA21-A/J-12 was started at 1933 hours with a starting heat of 197°C and weld number MUB-MA21-G/J-11 was started at 1925 hours with a starting heat of 191°C. ZPMC was to monitor the heat controlled cool down per the submittal.

UT

This QA inspector also performed UT verification after ZPMC had completed and accepted the weldments. This QA inspector performed 10 % of the weld lengths for review. At the time of the QA review the weldments appeared to be in conformance. The following is a list of weldments reviewed; Side Plates, SP 653-001-043, SP 645-001-001, SP649-001-001, SP 642-001-001, SP642-001- 031,033,035,037 and 039, SP653-001- 031,033,035, 037 and 039. Bottom Plates, BP311-001-033,035,037 and 039 and BP314-001-033,035,037 and 039. A TL-6027 will be generated for these locations.

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Summary of Conversations:

As noted above.

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 , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
