

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-000261**Date Inspected:** 20-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhou Daging**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:** Welder/ Welding Operator Qualification Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the fabrication facility of Zhenhua Port Machinery Company (ZPMC), LTD for the purpose of monitoring activities relative to the subsequent fabrication of the SFOBB Self Anchored Suspension Bridge. The following items have been observed,

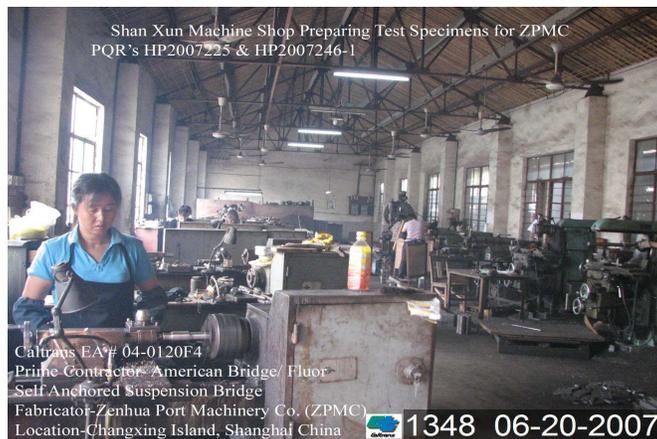
Item	Description	WBS	Dwg No.	Status
1	Machine Shop For PQR Specimens	N/A	N/A	N/A

Machine shop located at a location In Changxing Island that is away from the ZPMC fabrication facility.

The Caltrans QA Inspector traveled by shuttle bus supported by ZPMC. The Caltrans QA Inspector was accompanied by ZPMC representatives Mr. Xu Jun and Ms. Zhou Chun Mei. The purpose of this trip was to observe the preparing of machined specimens for ZPMC PQRs identified as HP2007225 & HP2007246-1. The Caltrans QA Inspector observed that this machine shop is located in an area that appears to be residences for living. The following digital pictures capture a portion of the Caltrans QA Inspector's observations.

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2	Machining Of Macroetch Specimens	N/A	N/A	N/A
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3	Machining of Mechanical Specimens	N/A	N/A	N/A
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The Caltrans QA Inspector observed that the machine shop is in the process of preparing, reduced section tension specimens, standard all weld metal tension specimens, side bend specimens, charpy vee notch specimens and also macroetch test specimens. Based on random observations and random dimensional verification performed utilizing a digital caliper it appears that the preparation of the test specimens for PQR tests identified as HP2007225 and HP2007246-1 is progressing in general compliance with AWS D1.5 (2002) Figures 5.9, 5.10, 5.11, 5.13 and also macroetch test sample criteria.

4	Welder/ Welding Operator Qualification Testing	N/A	N/A	N/A
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The Caltrans QA Inspector was accompanied by ZPMC representative Mr. Xu Jun, ABF representatives Mr. Kevin Dye and Dustin Brungardt for the purpose of traveling to a remote ZPMC location on Changxing Island for the continuing observation of in process Welder and Welding Operator qualification tests. As previously addressed this test facility of ZPMC is an established Welder/ Welding Operator qualification test facility at an area located approximately 15 to 20 minutes traveling by car from the main facility in Changxing Island. The Caltrans QA Inspector observed numerous Welder's and Welding Operator's in process of attempting qualification utilizing the shielded metal arc welding (SMAW) process, the flux cored arc welding (FCAW) process and also the submerged arc welding (SAW) process. The Caltrans QA Inspector observed that there are Moody International Representatives who are performing the monitoring of these Welder/Welding Operator Qualification tests. The Caltrans QA Inspector observed that there is a Moody International Certified Welding Inspector (CWI) identified as Mr. Zhou Daging with

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three assistants that are monitoring the Welder and Welding Operator qualification testing. Based on information provided by Mr. Zhou Daging there are eighteen (18) welders attempting qualification testing utilizing the flux cored arc welding (FCAW) process, nineteen (19) are attempting qualification testing utilizing the shielded metal arc welding process and two (2) are attempting welder operator qualification utilizing the submerged arc welding (SAW) process. These tests are all being attempted for qualification for unlimited thickness. Below are digital pictures of the Caltrans QA Inspector's observation of the activities being performed.



5	Welder/ Welding Operator Qualification Testing	N/A	N/A	N/A
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ZPMC representatives have advised the Caltrans QA Inspector that subsequent radiographic testing will be performed of the welder/welding operator qualification test plates that are visually compliant.

Based on random observations it appears that the observed welder/ welding operator qualification testing being performed is progressing in general compliance with AWS D1.5 (2002).

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Cuellar,Robert	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer