

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-000285**Date Inspected:** 12-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	WQT	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed welder qualification testing (WQT) by Moody International Inspectors Feng Lin Yao, Tang Li Pang, Certified Welding Inspector Zhou Daqing and He Jia Min at ZPMC today. There was one ZPMC Certified Welding Inspector, Xu Xian Ping with four assistants and two American Bridge/Fluor employees Mr. Danny McDonald and Certified Welding Inspector Mr. Warren Buehler. There were a total of 59 welders which attempted welder qualification test for yesterday in the shield metal arc (SMAW), submerged arc (SAW) and the flux cored arc (FCAW) welding process. There were of total of 32 FCAW welder tests attempted with only 16 passing final visual inspection, and a total of 22 SMAW tests attempted with only 11 passing final visual inspection and a total of 5 SAW tests attempted with 2 passing final visual inspection. Moody International Certified Welding Inspector Zhou Daqing performed the final visual inspections. The Moody International, ZPMC and ABF inspectors were observed checking the welding parameters for the welders being tested. A random inspection was made of the various volt/amp gauges and temperature gauges for calibration of which all were found to be in a current state of calibration.

Summary of Conversations:

No relevant conversations took place on this date.

Comments

WELDING INSPECTION REPORT

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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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
