

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-004192**Date Inspected:** 21-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Zhang Bao**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 Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Assembly Bay II

Mid bay-

A observed the in process joining of deck panels DP191-001 to DP164-001 by the SAW process. QA measured welding parameters in accordance with welding procedure specification WPS-B-T-2221-B-L2C-S-2 utilizing non corroded or detritus bearing 4.0 mm diameter H14 electrode wire by qualified welding operator Wang Lanying 045265. Measured amperage at 578.0. Voltage at 31.0, travel speed at 525 mm per minute. AB/F QC personnel Li Hao was present for this welding evolution.

QA observed at edge panel assembly CA022 for lift 5AW welds 56, 54, & 52 that qualified FCAW Welding Operator Li Xianyou 047866 was about to deposit weld metal over paint and corrosion. QA spoke with ZPMC QC Geng Wei about this condition and he directed the welder to grind the affected locations to bright shiny metal prior to further deposits.

5BW- QA observed the in process joining of floor beam connections of SSD10 at Panel Point 32 weld number 130

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by the SMAW process. QA measured welding parameters in accordance with welding procedure specification WPS-B-P-2213-B-U2-FCM utilizing 4.0 mm diameter electrode by qualified welder Yang Changming 0582432. Measured amperage at 184.0. Voltage at 24.0, travel speed at 113 mm per minute. ZPMC QC personnel Wu Shi Gao was present for this welding evolution. QA measured root openings that did not exceed 5.0 millimeters between the existing tack welds on both SSD10A-PP032-013 and SSD10-PP032-130. Subsequently QA observed clamps, chains and winches normally utilized to draw pieces into place were used on existing longitudinal diaphragm stiffener plates, specifically LD003-009 vertical stiffener weld numbers 001 & 002. This QA inspector witnessed this act near the end of the tack welding evolution. Photographs are available and will be documented within an Incident Report for further disposition and resolution.

The above mentioned items, as observed and documented by QA and except as reported in an incident report, appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

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 138-1694-2685, who represents the Office of Structural Materials for your project.

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