

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-004298**Date Inspected:** 16-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:** Sun Wei**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:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

This QA inspector monitored ZPMC performing tack welding, implementing the new welding procedure specification WPS-B-T-2342-U5 (U-Rib) on Deck Panel DP298-001. Observations of Welding Current (Amps & Volts), Travel Speed, Flow rate and Electrode extension appear to be in compliance with this WPS. Items related to Filler metal such as specification, brand and classification can not be verified at this time due to ZPMC using filler metal taken from a bulk source and manually loading this filler metal on a spool for the consumption in this semi-auto process. ZPMC was observed having wire feed problems and due to this issue the tension wheel on the welding machine was replaced with a new one. However this did not correct the problem and possibly made the problem worse, in any case the old tension wheel was reinstalled. It was also observed by this QA inspector that a ZPMC worker was needed to monitor and manually manipulate the wire spool in order to maintain proper wire.

Summary of Conversations:

No relevant conversations spoken on 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 Dautermann, Peter (707) 552-7715, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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