

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004424**Date Inspected:** 13-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:	Wu Ming Kai	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 & Tower	

Summary of Items Observed:

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Bay 3:

The QA Inspector randomly observed ZPMC welder Wang Hong Bo ID 203206, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2F (Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-2112-FCM, to tack weld I-Ribs to Side Plate SP464-001 Weld Joint (WJ) 009/010. The QA Inspector randomly observed ZPMC QC under the supervision of ZPMC CWI Wu Ming Kai, monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Jiang Jing Teng ID 046830, utilizing the SMAW Process in the 2F (Horizontal Fillet) Position with ZPMC WPS WPS-2112-FCM, to tack weld T-Ribs to Bottom Plate BP091-001 WJ 009. The QA Inspector randomly observed ZPMC QC under the supervision of ZPMC CWI Wu Ming Kai, monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder He Yu Mei ID 048625, utilizing the Flux Cored Arc Welding (FCAW) in the 2G/2F (Horizontal Groove/Fillet) Positions with ZPMC WPS WPS-B-T-2332-TC-P4-F to weld the

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Flange Plate Assembly to 9M Single Diaphragm WD1-A8 at WJ's WD1-A8-1-9 and WD1-A8-1-10. The QA Inspector randomly observed ZPMC QC under the supervision of ZPMC CWI Yu Dong Ping monitoring weld parameters. The weld parameters appeared to comply with contract requirements.

OBG Bay 4:

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Xu Hai perform a final 10% Magnetic Particle Testing (MT) examination of the fillet welds on Side Plates SP616-001 (SP616A-Yellow Tag # 001012) and SP720-001 (SP720B-Yellow Tag # 001016). There appeared to be no indications and ZPMC QC accepted the above listed welds.

The QA Inspector performed a final 10% random Magnetic Particle Testing (MT) verification of the fillet welds on Side Plates SP616A-Yellow Tag # 001012/Green Tag 001012) and SP720-001 (SP720B-Yellow Tag # 001016/Green Tag 001044). There appeared to be no indications and the QA Inspector accepted the above listed welds. Green Tag Documentation was signed and dated by ZPMC Representative Chen Chih Chien, ABF Representative Hu Gui Hua and CT QA Inspector Lot Number B75.



Summary of Conversations:

As noted in the above body 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 Joshua Ishibashi, 13764710411, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer