

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-004505**Date Inspected:** 27-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi, Le Li**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:**

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

OBG Sub-Assembly Shop – Bay 1

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, was present to monitor activities associated with the Production Monitoring Test (PMT) of Orthotropic Box Girder (OBG) Deck Panel U-rib welds. The PMT representing Deck Panels DP395-001 and DP152-001 was monitored. After MT of the tack welds was accepted by ZPMC Level II MT Technician, Wang Wei, the three ribs (six welds) were simultaneously welded to simulated deck plates in the horizontal groove (2G) welding position. The Welding Procedure Specification (WPS) used was WPS-B-T-2342-U1(Urib)-4. It is a combination procedure using gas metal arc welding (GMAW) for the root pass and submerged arc welding (SAW) for the cover or fill pass. The filler metals being used were verified to be as specified on the WPS; 1.4 mm diameter, ER70S-6 (JM-56) for GMAW and 4.8 mm diameter EH14K (H14) for SAW. During the test, the Caltrans QA Inspector recorded the parameters observed on the U-Ribs PMT Inspection Sheet, dated 10-28-08, for both welding processes. The name of the gantry operators and each of the welding operators' identification numbers were also recorded on the U-Ribs PMT Inspection Sheet. ZPMC Certified Welding Inspector (CWI) Chen Xi (07072021), and ABF QA Inspector Lv Yun were present during welding.

The final weld was visually examined and accepted by ZPMC CWI, Chen Xi; and ABF QA Inspector Lv Yun.

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All welds appeared to meet the specified visual examination acceptance criteria. After ultrasonic examination (UT) and acceptance by ZPMC Level II UT Technician, Tang Xing Shan, the Caltrans QA Inspector designated the locations for the required macro-etch specimens. All macro-etch specimens were prepared and found acceptable by ZPMC CWI, and ABF QA Inspector. The macro-etch specimens were then examined by the Caltrans QA Inspector and the depth of penetration on each measured and the results recorded on Caltrans Project 04-0120F4 SAS OBG Fabrication Macro Etch Log.

Heavy Machinery (Tower) Shop 2

The Caltrans QA Inspector also randomly observed machine SAW of fill passes Weld Nos. ESD1-SA388C/D-49A, 7, 25A, 37, 27A, 11, 29A, 41, 31A, 45. All of the above is one weld joint with alternating complete joint penetration (CJP) welds and partial joint penetration (PJP) welds. The "A" welds are CJP and the others are PJP. The machine SAW of Weld Nos. ESD1-SA388C/D-5, 26A, 39, 28A, 9, 30A, 43, 32A, 47, 50A was also observed.

The "A" welds are CJP and the others are PJP. All of the above are on the East Tower, Lift 1, Skin "C". The two welding operators were Xue Yian (I. D. No. 040636) and Sun Ping (I. D. 040741). The welding was in the flat groove (1G) position. The two Welding Procedure Specification (WPS) Nos. were WPS-B-T-2221-B-U3c-S-2 for the CJP and WPS-B-T-2321-P3-S-2 for the PJP. Certified Welding Inspector (CWI), Le Li (CWI No. 08082291) was monitoring this welding as were two additional ZPMC QC inspectors and one ABF QA Inspector. The QA Inspector verified the qualifications of the welding operators, the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm.

All above observations appeared to meet the requirements of the job specifications.

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 Peter Dautermann (1500219953) China, who represents the Office of Structural Materials for your project.

Inspected By:	Jobes, Kenneth	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
