

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-004547**Date Inspected:** 04-Nov-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:** Lvliqing and Hu Wei Qing**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 and SAS Tower Fabrication**Summary of Items Observed:**

On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

The QA Inspector has randomly observed the following activities on sub-assembly Bays mentioned below;

Bay 7: OBG - Floor Beam Sub Assembly

This QA Inspector randomly observed ZPMC welder Zhang Qing Quan ID#044774 and ID #044815 utilizing the FCAW Process in the 2G (Hor. Groove) Position with WPS-B-T-2232-Tc-U4b-F and a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H, semi automatic to weld root and cover passes on web plate to flange tee joint on floor beam FB011-013-043 and FB016-020-045 respectively. The QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring preheat and weld parameters.

FCAW(2F) fillet welding on stiffener and flange to web plate FB016-022-017/018 and FB016-022-003 and 011 utilizing the FCAW Process with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H following WPS-B-T-2132-3 this QA observed. ZPMC welders ID #066687, ID #044824 and ID #067601 were seen performing the task. Tack/fit-up of various stiffeners to web plate on floor beam FB020-003 weld joints 096/097, 084/085 and FB019-003-104/105 using TL-508 electrode was observed.

Bay 8: Tower Diaphragm

This QA Inspector randomly observed ZPMC welder ID number 202654 and ID #048433 utilizing the FCAW

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Process in the 3G (Vertical Groove) Position with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H, semi automatic with ZPMC WPS WPS-B-T-2233-B-U3-F, to weld fill pass on groove (bent heavy plate) splice butt joint on Tower Diaphragm Flange Sub-Assembly NSD1-SA325 weld joint 7A and 3B. The QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

The QA Inspector randomly observed ZPMC Welders ID #045218 and ID #051324 utilizing the Shielded Metal Arc Welding (SMAW) Process in the 3G (Vertical Groove) Position with Excalibur E9018M H4R, 4.8mm diameter electrode following ZPMC WPS WPS-B-T-3313-Tc-P5 to weld tower double diaphragm PJP root pass on 75mm thick web plate to 60mm thick stiffener plate tee joint SSD1-SA244 weld joints 14, 15, 16, and 17. The QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

Heat straightening was also observed on tower diaphragm flange WSD1-SA414 weld joints 14A/B, 15A/B, 13A/B, 12A/B, 11A/B, 17A/B, 16A/B and 10A/B due to welding distortion. Natural gas was used with heating temperature of less than 650 degree C following procedure HSR1(T)-5356.

This QA observed ZPMC weld, ID #201583 and ID #067138 utilizing the FCAW Process in the 2F (Horizontal) Position with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H semi automatic with ZPMC WPS WPS-B-T-2132 to weld fillet cover pass on fillet weld connection between tower diaphragm plate to diaphragm flange SSD1-SA361-16. The QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

Summary of Conversations:

No significant conversation occurred today.

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, (858) 232-7081, who represents the Office of Structural Materials for your project.

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