

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-004881**Date Inspected:** 04-Dec-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:	Huang Wen Pang 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 performed 10% Magnetic Particle Testing (MT) of fillet welds on stiffener and flange to web plate of floor beam FB027-005B for green tagging.

The QA Inspector randomly observed ZPMC welder Duan Xin Zhi ID Number 050502 utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld the fill pass on unequal thickness of 16mm:12mm plate splice butt joint of floor beam FB003-157-001. QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring weld parameters.

This QA Inspector randomly observed ZPMC welder Zhang Qing Quan ID #044774 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 fill pass on 200mm stiffener end to web plate of FB027-004-111. FCAW(2F) fillet welding on stiffener to web plate FB027-004 weld joints 120/121 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 also observed. ZPMC welder Liu Kaige was seen performing the task. The QA

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Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring preheat and weld parameters.

Bay 8: Tower Diaphragm

The QA Inspector randomly observed ZPMC welder ID Number 043247 and ID #045273, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-L2c-S-2, to weld the CJP cover pass on 18mm thick plate splice butt joint and unequal thickness 30mm:12mm butt joint of floor beams FB024-009-108 and FB011-029-026 respectively. QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring weld parameters.

Flame bevel cutting of tower diaphragm plate South 56M in progress this QA observed.

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
