

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-005286**Date Inspected:** 16-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao Lei**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 Segment**Summary of Items Observed:**

CALTRANS OSM Quality Assurance (QA) Inspector, Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. QA Inspector and/or found the following:

Outside Bay 13 lift 5BW: QA Inspector randomly observed ZPMC qualified welder Chen Hong Jun ID#067609 welding on panel point floor beam 33 joint number SSD11A-PP33-171. Welder was observed welding in the 4G (overhead) position utilizing Shielded Metal Arc Welding (SMAW) process with a 4 mm diameter electrode THJ506Fe-1 (E7018-1). QA Inspector observed the ZPMC QC Inspector Wu Shigao verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 50°C and measured the welding parameters to be 175 amps, 22 volts, a travel speed of 125 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-P-2214-TC-U4b-FCM.

Outside Bay 13 lift 4BW: QA Inspector randomly observed ZPMC qualified welder He Junrong ID#201215 welding on panel point floor beam 27 joint number SSD11A-PP27-221. Welder was observed welding in the 2G (horizontal) position utilizing Flux Core Arc Welding (FCAW) process with a 1.4 mm diameter electrode E71T. QA Inspector observed the ZPMC QC Inspector Wang Tai verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 170°C and measured the welding parameters to be 270 amps, 28 volts, a travel speed of 480 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-T-2232-TC-U4b-F-1.

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Summary of Conversations:

No significant conversations this day.

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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
