

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-000008**Date Inspected:** 09-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liu and Huang Wei**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:** N/A**Summary of Items Observed:**

This Office of Structural Materials Quality Assurance Inspector observed welding and quality control functions during procedure qualification testing at the ZPMC facility in Shanghai, Republic of China today.

This Quality Assurance Inspector observed the Quality Control Inspector, Mr. Liu Liu and Mr. Huang Wei witnessing the running of a flux-cored arc welding procedure qualification test HP2006106 in the shop at ZPMC. The test was being run to Paragraph 5.12 for minimum heat input in the vertical welding position (3G). The welders were Lei Li Chao and Zhang Xing Jin who were using Hyundai, Supercored 71, and 1.4 millimeter diameter wire with welding procedure specification PWPS-B-T-2233FB. Welding of this procedure qualification was not completed by the end of the shift so welding will be continued tomorrow on Friday November 10, 2006.



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Summary of Conversations:

Discussed the radiographic film from yesterday with David McClary concerning the techniques used. Mr. McClary is going to review the radiographic techniques used by ZPMC. Some of the issues discussed were that no markings appeared on the plate showing location markers and there were no signs of where the film was placed on the back side of the plate. The black soot from welding was still there and failed to show any signs of handling.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Lowry, Patrick	QA Reviewer
