

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 #: 50.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000041**Date Inspected:** 13-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), Jiangyin**Location:** Shanghai, China**CWI Name:** Liu Liu**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.

Item	Description	WBS	Dwg No.	Status
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1

This Quality Assurance Inspector observed the Quality Control Inspector, Mr. Gu Xin Zai witnessing the running of the gas metal arc welding procedure qualification test HP2006119 in the shop at ZPMC. The test was being run to Paragraph 5.13 for this flat groove weld (1G) position. The welder was Lei Li Chao who was using Hyundai, SM 70, and 1.4 millimeter diameter wire with 10% CO2 gas and 90% Argon at a flow rate of 21 Liters/minute and welding procedure specification PWPS-B-T-2241-F. Welding of this 1G procedure qualification was completed at 1430. (See Welding Inspection Report 6032 B72-053-06 dated 11-11-2006 for details)

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Summary of Conversations:

In a conversation held with Mr. Liu he stated that this procedure qualification test plate would be x-rayed this evening in preparation for machining the samples tomorrow for mechanical testing.

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