

**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-000051**Date Inspected:** 11-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Liu Liu			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	PQR Test plates		

**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector witnessed welding of a Procedure Qualification (PQR) test plate using gas shielded flux cored arc welding (FCAW-G) using Supercored 71H electrode, in the 1G (horizontal) position. The welding was performed per the AWS D1.5, 2002 Section 5.12 requirements. The QA inspector noted that the test was started on 01-08-2007 with the QC inspector Huang Wei, continued on 01-11-2007 with the QC inspector Lu Tien Hua and completed on 01-11-2007 with the QC inspector. The welding appeared to comply with the contract documents. Caltrans lot number B31-002-07 was assigned for tracking purposes.

The Caltrans Quality Assurance (QA) Inspector witnessed welding of a Procedure Qualification (PQR) test plate using gas shielded flux cored arc welding (FCAW-G) with Supercored 71H electrode, in the 3F (vertical up) position. The welding was performed per the AWS D1.5, 2002 Section 5.10 requirements. The welding appeared to comply with the contract documents. Caltrans lot number B31-003-07 was assigned for tracking purposes.

**Summary of Conversations:**

At the completion of the welding the QC inspector Liu Liu reported that the test plates were found to be visually acceptable in accordance with the contract documents.

**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.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Lanz,Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright,Mark	QA Reviewer
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