

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-000080**Date Inspected:** 05-Mar-2007**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:** Bing Xu**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:** NA**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Mr. Mike Hasler is present for the welding qualification testing applicable for welding qualification record (PQR) HP200707 scheduled for this project.

ZPMC resumed the procedure qualification testing as mentioned above. That was started the previous day.

Caltrans QA Inspector, Mr. Hasler witnessed ZPMC, welder operator, Mr. Zhang Xing Jin perform submerged arc welding (SAW) per welding procedure specification (WPS) PWPS-B-T2221-FB-1. Caltrans QA observed ZPMC, QA Inspector Mr. Hu Gang and American Bridge/Fluor Inspector, Mr. Bing Xu monitoring and supervising the testing for the minimum heat input criteria per AWS 5.12.2, amperages, voltages, travel speeds, preheat and heat interpass temperatures. Caltrans QA Inspector recorded welding parameters for a total of 9 through 23 passes. Caltrans QA Inspector verified that the welding parameters taken by ZPMC QC and ABF QC inspectors appeared to be accurate and in accordance with the contract documents. ZPMC QA Inspector, Mr. Hu Gang submitted Mr. Bing Xus American Welding Society welding inspector certification certificate for review and records. This record is on file at the Caltrans Field Office for future reference.

Summary of Conversations:

At 1630 hours ZPMC QA Inspector, Mr. Hu Gang terminated welding after the completion of the 23rd weld pass. Mr. Gang stated that there is not enough time to complete the welding of the test plate during this work shift. Mr. Gang also stated that welding would be resumed on the test plate the following work day.

WELDING INSPECTION REPORT

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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: Hasler, Mike

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer