

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-000085**Date Inspected:** 08-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:** 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:** Bid: 52, 55 Tower & Girder**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present to witness procedure qualification (PQR) testing for HP2007715 as requested by ZPMC. The test plate was welded in the 3F (vertical) position, using the flux core arc welding (FCAW) semi-automatic welding process. The test consisted of a maximum single and minimum multi pass weld. The welding consumable is identified as E71T1-1 electrode, 1.4 mm diameter. The welding was performed in accordance with AWS D1.5, Section 5.10.3 fillet weld soundness requirements. The welding appeared to comply with the contract documents. See Caltrans Welding Witness Report (TL-6032), dated March 8, 2007 for additional information. Caltrans QA Inspector assigned lot number B49-004-07 for maximum single pass weld and B49-005-07 minimum multi-pass weld.

Summary of Conversations:

At 1000 hours ZPMC Quality Assurance Inspector, Mr. Lu Gang notified Caltrans QA that ZPMC would be performing procedure qualification (PQR) testing for HP200715.

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
