

**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-000091**Date Inspected:** 09-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:** Xu Bing**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:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the mechanical testing on the welding qualification tests for the procedure qualification record (PQR) PQR 200707 and PQR 200708 scheduled for this project. The testing was at the ZPMC facility in Shanghai, China. The QA Inspector observed tensile test on reduced sections and all weld metal specimens along with side bends, Charpy Vee Notch (CVN) and macro etch tests. The test was performed per the AWS D1.5, Section 5.18 requirements. The tests appeared to comply with the contract documents with the exception of 5 test samples from the PQR HP200707 due to the Charpy Vee Notch (CVN) impacts were lower than the required by table 12.1 for fracture critical members. The actual absorbed energy recorded for the 5 test samples were 29/24/21/22/24 Joules, the minimum required value was 34 Joules. The QA Inspector issued a lot number of B71-008-07 and B71-009-07 after the completion of the PQR mechanical test. See TL\_6032s for details of this test.

The digital photograph below shows the CVN test coupons that failed on the PQR 200707.

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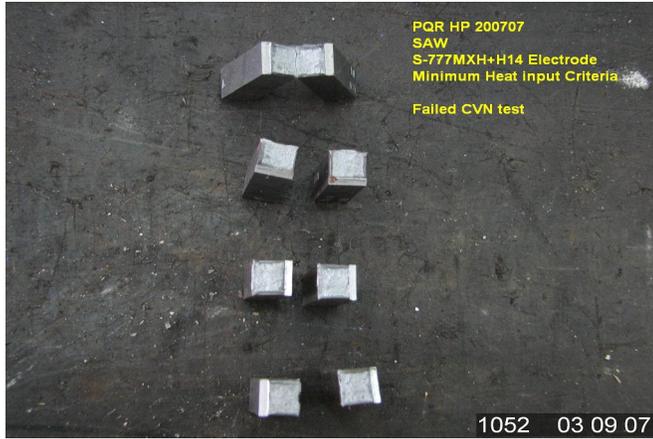
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QA inspector did not have any significant conversation on this date.

## 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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<b>Inspected By:</b>	Acuna,Alfredo	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary,David	QA Reviewer

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