

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-000102**Date Inspected:** 19-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:** Lui Lui**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:** PQR mechanical testing**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans QA inspector was present as requested by ZPMC to witness the mechanical testing for HP200710, HP200711, HP200713-1 and HP200716 as follows:

HP200710 FCAW Complete Joint Penetration Groove Weld, 1G position with Ceramic Backing. AWS D1.5, Section 5.13.

Side Bend Specimens

Reduced Section Tension Specimens

Macro Specimens

Testing performed to AWS D1.5, Section 5.18 requirements.

Caltrans assigned lot number B49-010-07.

HP200711 FCAW/SAW Complete Joint Penetration Groove Weld, 1G position with Ceramic Backing. AWS D1.5, Section 5.13.

Side Bend Specimens

Reduced Section Tension Specimens

Macro Specimens

Testing performed to AWS D1.5, Section 5.18 requirements.

Caltrans assigned lot number B49-011-07.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

HP200713-1 FCAW T-Joint Fillet Weld, minimum multi size fillet weld, 2F position, AWS D1.5 Section 5.10.

Micro Specimens

Testing performed to AWS D1.5, Section 5.10.3, fillet weld soundness requirements.

Caltrans assigned lot number B49-012-07.

HP200716 SAW T-Joint Fillet Weld, maximum single pass and minimum multi size fillet weld, 1F position, AWS D1.5 Section 5.10.

Micro Specimens

Testing performed to AWS D1.5, Section 5.10.3, fillet weld soundness requirements.

Caltrans assigned lot number B49-013-07.

ZPMC Quality Assurance Manager, Mr. Liu Liu submitted supporting testing documentation for review and records. The recorded test information appeared to be complete, accurate and complying with contract documents. The testing records are on file at Caltrans field office for future reference. See Caltrans Welding Witness Report (TL-6032), dated March 19, 2007 for additional information.

Summary of Conversations:

As identified within the contents of this report.

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
