

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-000103**Date Inspected:** 16-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Bing and Lu Jiang Ping	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 welding qualification testing pertinent for the welding qualification record (PQR) HP200712-3 (Dual Process PQR FCAW and SAW) scheduled for this project. ZPMC, welder operator Zhan Xing Jin was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-223(2)1T-1 for the PQR identified as HP200712-3. Base metal was designated as A-709-50-2/Z25 (Heat # 06102938N) and appeared to meet the non fracture critical impact test requirement. The root opening of the joint was approximately 6 mm. ZPMC followed AWS 5.13 the production procedure WPS using the automatic submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter EH-14 electrode. The QA Inspector verified amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspectors recorded welding parameters for a total of 6 passes. The QA inspectors observed that the welding parameters taken by ZPMC QA inspector Hu Gang appeared to be accurate and in accordance with the contract documents. ZPMC QC (CWI) Xu Bing witnessed the testing and performed visual weld inspections. The welding was still in process at the end of shift (PQR was 90 % completed).

Summary of Conversations:

The QA inspector did not have any relevant conversations 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Acuna, Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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