

**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-000128**Date Inspected:** 26-Apr-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:** Song Wei min**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 Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

At 1400 hours, ZPMC resumed the procedure qualification testing for HP200778. With the original start date as reported in the Welding Inspection Report dated April 25, 2007. Caltrans QA Inspector witnessed ZPMC, welder, Mr. Zhu Hai Ping perform shield metal arc welding (SMAW) in accordance with welding procedure specification (WPS) PWPS-B-T3214 requirements. Caltrans QA observed ZPMC, QA Inspector Mr. Hu Gang and American Bridge/Fluor, Quality Control (QC) subcontractor, Bureau Veritas (BV) inspector, Mr. Song Wei min monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and interpass temperatures. Caltrans QA inspector recorded welding parameters for a total of 8 through 11 weld passes, which took five electrodes to complete one weld pass. Caltrans QA verified that the welding parameters taken by ZPMC QC inspector appeared to be accurate and in accordance with the contract documents. Caltrans QA Inspector observed Mr. Sung perform visual inspection of the completed weld test. Items observed by Caltrans QA appear to comply with the project documents. Lot number B49-021-07 was assigned to the test plate. See Caltrans Welding Witness Report, TL-6032, dated April 26, 2007 for additional information.

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# WELDING INSPECTION REPORT

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## 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.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary, David	QA Reviewer

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