

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000277**Date Inspected:** 09-Jul-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:	N/A	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:	WQT & PQR HP2007370	

Summary of Items Observed:

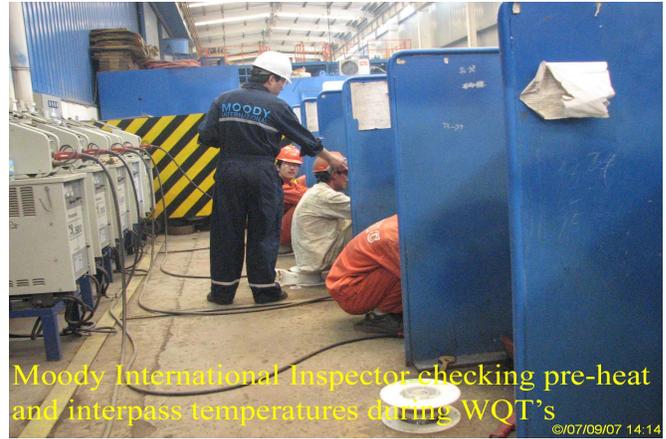
Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed welder qualification testing (WQT) by Moody International Inspectors Feng Lin Yao, Tang Li Pang, Zhou Daqing and He Jia Min at ZPMC today. There was one ZPMC Certified Welding Inspector, Xu Xian Ping with four assistants and one American Bridge/Fluor employee Mr. Danny McDonald. There were a total of 40 welders which were to be tested today in the shield metal arc (SMAW), submerged arc (SAW) and the flux cored arc (FCAW) welding process. Both the Moody International and ZPMC inspectors were observed checking the welding parameters for the welders being tested. A random inspection was made of the various volt/amp gauges and temperature gauges for calibration of which all were found to be in a current state of calibration.

Radiographic Film Review: This Quality Assurance Inspector reviewed film for procedure qualification test HP2007370 which was a 26 millimeter thick complete butt joint penetration weld. While there was some porosity observed in the film the weld appeared to be in compliance with the code and specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No relevant conversations took place 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.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
