

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-000307**Date Inspected:** 14-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:	PQR HP2007144-1	

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 witnessing ZPMC performing shield metal arc welding (SMAW) procedure qualification record (PQR) HP2007144-1, PWPS-B-T-3213 test. The welder is identified as Mr. Zhu Hai Ping, welding passes 7 layer 6 through pass 17, layer 11. The test plate material type is identified as A709 Grade HPS485W and thickness, 90 mm. The PQR complete joint penetration weld joint testing was performed in the vertical up (3G) position. The welding consumable is identified as 4.0 mm electrodes, classification E9018M-H4R, specification AWS A5.5. Caltrans QA observed ZPMC QA Inspectors/Certified Welding Inspectors, Mr. Wei Huang and Xu Bing plus one associate monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and inter-pass temperatures. Also present at the test site was American Bridge/Fluor (ABF) Certified Welding Inspector (CWI), Mr. Dustin Brungardt. QA observed that the wind velocity at the ZPMC testing site appear to be in conformance with AWS D1.5, paragraph 4.14.3 requirements. Welding was not completed and will be continued tomorrow.

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

WELDING INSPECTION REPORT

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for your project.

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