

**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-000599**Date Inspected:** 24-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Liang Zhang**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:** 77 Mock-Up Skin Pl. E**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 The Caltrans QA Inspector was present for the dry powder Magnetic Particle (MT) inspection of Skin Plate E of the 77 Meter Mock-Up. The inspection included the root pass of sides 1 and 2. The plate length was 2 meters with a 3.0 inch thick plate being welded to a 4.0 inch thick plate. Preheat was maintained at approximately 110 plus degrees Celsius throughout the inspection period. The welding parameters recorded by this QA Inspector were, DC volts 33, Amps was observed at 661 with the travel speed of 607.5 mm per inch. The welding operator was Cao Xiaohua and the QC that was present was Le Feng. The attending CWI was Xu Liang Zhang. The dry powder MT testing of the root on side two was witnessed by the Caltrans QA Inspector and was performed by Cai Xin Xin who was testing at a 45 degree angle to the weld joint in one direction only. The 100% MT testing performed by the QA Inspector of the root pass on side 1 and side 2 were found to be in compliance with project specifications.

**Summary of Conversations:**

There were no conversations pertinent to this project that took place during this shift.

**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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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Smith,David	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer
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