

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000459**Date Inspected:** 14-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Jian 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:** Mock Up**Summary of Items Observed:**

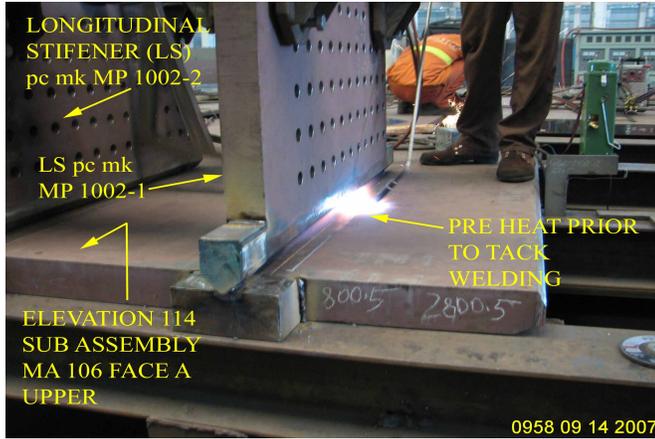
Elevation 114:

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding being performed for the fabrication of the Mock Up at elevation 114. The QA Inspector randomly observed ZPMC qualified welders Ye Bin and Liu Guoxian, utilizing the Flux Cored Arc Welding (FCAW) process to weld longitudinal stiffener MP1005-1 to sub assembly MA112 Face C. Both welders were utilizing ZPMC weld procedure specification WPS-B-T-2232-TC-P5-F-1. The QA Inspector observed ZPMC CWI Liu Jian Ping monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows: welding amperage 310 amps, welding voltage 30.8 volts, a travel speed of 310 millimeters per minute for Mr. Ye, and 302 amps, 31 volts with a travel speed of 305 millimeters per minute for Mr. Liu. Weld parameters appeared to comply with the above approved ZPMC weld procedure specification (WPS).

The QA Inspector randomly observed ZPMC welding personnel performing the lay out of the tack welds for attaching longitudinal stiffeners piece marks MP 1001-1, MP 1002-1, MP 1002-2 and MP 1002-3 to Mock Up sub assembly MA 106 Face A Upper. The QA Inspector also observed ZPMC welding personnel applying preheat to the weld joint area attaching longitudinal stiffener piece mark MP 1002-1 to sub assembly MA 106. The following photographs provide additional detail.

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Summary of Conversations:

There were no relevant conversations.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer