

**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-000554**Date Inspected:** 29-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Bing Xu, Xu Lefeng**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:** 114 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance Inspector observed ZPMC ultrasonic technicians Li Liming and Q Shinquin performing ultrasonic testing on 114 Meter Mock-Up, MUSC-MA-106, Face A Sub Assembly complete joint penetration Tee Welds number 3, 4, 5 & 7. These were on repairs completed earlier today. Welds 3 & 5 were accepted, however weld 4 had a 20 millimeter long indication and weld 7 had a 55 millimeter long indication causing both welds to be rejected by the ZPMC ultrasonic technicians

This Quality Assurance Inspector observed ZPMC qualified welders Zhai Qingshan, welder identification 058026 and Yang Lei, welder identification 040690 welding repairs on 77 Meter Mock-Up, MUSA-MA1 Face "E" Plate Sub-Assembly. The welding procedure being followed was WPS-345-SMAW-1G (1F)-Repair and the amperage, travel speed and inter-pass temperatures were all found to be within an acceptable range of the procedure.

This Quality Assurance Inspector observed ZPMC qualified welder Bai Weiming, welder identification 040434 welding complete joint penetration tee-welds on 114 Meter Mock-Up, MUSA-MA110 Face "D" Plate Sub-Assembly. The welding procedure being followed was WPS-B-T-2232-TC-U5-F and the amperage was checked and found to be 315, the voltage 32, travel speed 330 millimeters per minute and an inter-pass temperature of 139 degrees C.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Summary of Conversations:

There were no significant conversation this evening.

## 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>	Berger, Bruce	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran, Jim	QA Reviewer

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