

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-000736**Date Inspected:** 02-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jiang Weifeng**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:** Bend Tests-Welder Qualification, Receive Plate**Summary of Items Observed:**

Side Bends Tests:

Caltrans Quality Assurance (QA) Inspector Ken Jobs randomly observed mechanical testing of side bend test specimens for welder qualification. QA Inspector Jobs randomly observed Moody International Mr. Jiang Weifeng (American Welding Society Certified Welding Inspector No. 06010931) and ABF representatives Mr. Danny McDonald and Mr. Josh Meadows visually inspect the side bend specimens after testing. The results are as follows:

Seventy (70) Side Bend Test Specimens

Specimen #7101-1&2, Specimen #7102-1&2, Specimen #7103-1&2, Specimen #7106-1&2, Specimen #7107-1&2, Specimen #7108-1&2, Specimen #7109-1&2, Specimen #7110-1&2, Specimen #7112-1&2, Specimen #7113-1&2, Specimen #7114-1&2, Specimen #7115-1&2, Specimen #7118-1&2, Specimen #7120-1&2, Specimen #7121-1&2, Specimen #7124-1&2, Specimen #7129-1&2, Specimen #7130-1&2, Specimen #7131-1&2, Specimen #7001-1&2, Specimen #7002-1&2, Specimen #7003-1&2, Specimen #7005-1&2, Specimen #7106-1&2, Specimen #7008-1&2, Specimen #7013-1&2, Specimen #7015-1&2, Specimen #7016-1&2, Specimen #7017 1&2, Specimen #7023-1&2, Specimen #7024-1&2, Specimen #7026-1&2, Specimen #7030-1&2, Specimen #7031-1&2, Specimen #7035-1&2,

The tests results identified above have been observed and recorded as being compliant with the test requirements as listed within AWS D1.5 (2002). Also, See ZPMC Bending Test Record of Welder Qualification for more detail information, Report # WT-LX-20071102-1.

Receive Plate:

Caltrans QA Inspector Ken Jobs also verified the receiving of one plate – Batch No. 32, No. 2306 (I. D.)

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#WY070836Q083, ASTM A709M Grade 345-F2-X, Heat No. 07303020NO). The QA Inspector observed that the original manufacturer's identification markings had been transferred to the plate material. The plates were observed for their general condition and markings. Plate material thickness is 30 mm. ZMPC QC representative, Xu Jun, was present during these verifications. The plate is designated as A709M-345F2-X. ZMPC QC representative, Xu Jun, was present during these verifications. Lot No. B93-011-07 was assigned to this plate.

Summary of Conversations:

As identified within the contents of this report.

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:	Jobes, Kenneth	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
