

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-000797**Date Inspected:** 07-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hou Jing Tao & 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:	Caltrans Mockup	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Diaphragm Plate Sub-Assy	NA	NA	Welding

Mock-Up 89M, Diaphragm Plate Sub-Assembly: ZPMC performed shielded metal arc welding (SMAW) at diaphragm plate to web plate, partial joint penetration (PJP) weld joint. Welder, identified as Mr. Mr. He Shi bing, welder stamp 066155, welding weld MUSB-SA13 B/C- 13 and Mr. Jiang Xia Yao, welder stamp 066243, welding weld MUSB-SA13 B/C- 14, fill pass weld in the horizontal position. The welders were using welding procedure specification WPS-B-T-3312-TC-P5, Revision 0. The welding was being monitored by ZPMC Quality Control (QC), Certified Welding Inspector (CWI), Mr. Shi Zhi and Bureau Veritas inspector, Mr. Huang at the welding station. Caltrans QA Inspector verified current welding parameters at approximately 240 amps and 150 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. The preheat temperature prior to the start of welding measures more than 195 Celsius (383 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. SMAW consumable is verified and identified as Excalibur 9018M MR, classification E9018M-H4R, specification AWS A5.5, and diameter 4.8 mm (.189 inch).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
