

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000819**Date Inspected:** 05-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:** Sha Zhi & Xu Lifeng**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:**

Summary 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	Work in Progress

Mock-Up 89M, Diaphragm Plate Sub-Assembly: Caltrans QA Inspector observed shielded metal arc welding (SMAW) in progress. Caltrans QA Inspector observed two welders welding partial joint penetration (PJP) fill weld pass at web plate to diaphragm plate, weld MUSB-SA13 B/C 3 and MUSB-SA13 B/C 4. The welders are observed welding in the horizontal position. The welders are identified as Mr. Liu guoxuan, welder stamp 066471 and Mr. Xu Wei, welder stamp 066155. The welders are using welding procedure specification WPS-B-T-3312-TC-P5, Revision 0. Caltrans QA Inspector observed ZPMC Quality Control (QC), Certified Welding Inspector (CWI), Mr. Shi Zhi and Bureau Veritas inspector, Mr. Xu Liang Zhang monitoring welding activities at the workstation. Caltrans QA Inspector measured current welding parameters at approximately 250 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 190 Celsius (374 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). Following digital picture illustrates welding in progress.

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
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Reviewed By:	Cuellar, Robert	QA Reviewer
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