

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-000921**Date Inspected:** 14-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ye Yong Jun**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:** 89 & 114**Summary of Items Observed:**

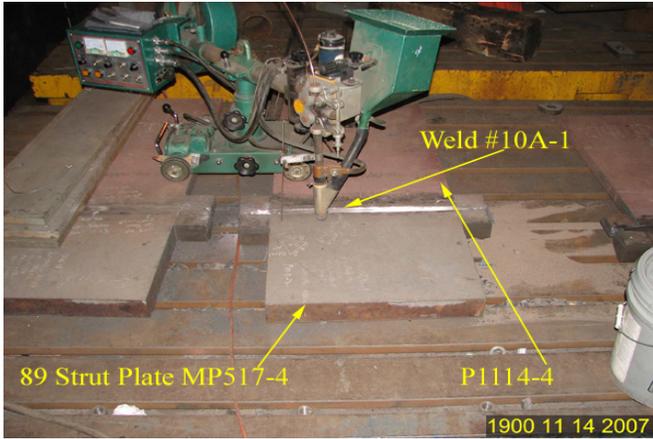
On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up Stiffener Plate MP517-4, 345 material & 45mm thick and P1114-4, 485 material & 75mm thick, weld 10B-1 was having filler material deposited by welder Jiang Jing Teng. The welder is certified for Shielded Arc Welding in the 1G position. The weld procedure used was WPS-B-T-4221-B-U3-S and the welding parameters recorded by this QA Inspector were, Amps 605, Volts 30.5, Travel Speed (T/S) 467mm/min. and Temperature 210c. The CWI present was Ye Yong Jun.

Item-2 114 Mock-Up Skin-B. Once the lifting devices were removed from the base material the weld areas were ground smooth. A Magnetic Particle (MT) test was performed by Zhenhua Port Machinery Company (ZPMC) certified Level II MT technician Cai Xin Xin and monitored by this Caltrans QA Inspector. This QA Inspector did MT selected areas of the ground smooth areas on plate MP1015 and found them to be in compliance with the project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer