

**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-000939**Date Inspected:** 19-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:** Huang Wei**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:** HP2007261**Summary of Items Observed:**

CalTrans Quality Assurance (QA) Inspector Dan Hernandez was on site at ZPMC Welding Lab to observe the welding of the Procedure Qualification Record (PQR) test plate HP2007261. PQR HP 2007261 is a single and multiple pass fillet weld test coupon welding in the 2F position. Welding was performed using the shielded metal arc welding (SMAW) process. Filler metal specification AWS A5.1 and classification E7018-1, electrode diameter 5.0 mm. Test plates were 90 mm thick in a T-Joint fit up. Welding was performed per AWS D1.5 2002, Section 5.10 Fillet Weld WPS Qualification. Welding was performed by Zhu Haiping. Total passes deposited were 4; pass #1 was a single pass and passes #2- #4 were multiple passes. The welding on the test coupon was completed and appeared to be in compliance with the contract documents. QA Inspector issued lot number L30-139-07 to the test coupon. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Haung Wei and Bureau Veritas Inspector Mr. Arbin Huang were observed monitoring welding activities at the workstation.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

### 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>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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