

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-000998**Date Inspected:** 26-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:** 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 mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fitup, welding and related activities associated with the fabrication of 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 89M Skin Plate D			In Progress

Caltrans QA Inspector observed SMAW in progress of Tack welding on Longitudinal Stiffener plates mp(538A, 538B, 540) to Skin Plate D. The weld joint is a Complete Joint Penetration (CJP) double bevel T-joint in the 2G position. The approved welders Ma Zhi Yong # 066139 was using approved welding procedure specification WPS-B-T-2212-TC-U5B. Caltrans QA Inspector observed welding parameters at approximately 216 amps, 26.5 volts and 165 millimeters per minute (mm/min) travel speed. Preheat temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SMAW welding consumable is verified and identified as classification E7018 TL 508 5mm diameter. An electrode oven was observed by Caltrans QA Inspector in use during the welding process. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Xu Lefeng and Bureau Veritas Inspector Mr. Li Wen Sheng were observed monitoring welding activities at the workstation.

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

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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