

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-001585**Date Inspected:** 13-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guo Gang, Wang Nam**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:** OBG & 114 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

This QAI observed ZPMC welder Li Meng Qian, welder identification 054460 performing flux core arc welding (FCAW) on side plate SP021-006-013. Some of the essential welding variables were checked and found to be as follows; 24 volts, 207 amperage and 111 millimeters per minute travel speed.

This QAI observed ZPMC welder Jiang Zhou, welder identification 040261 performing flux core arc welding (FCAW) on MUC-MA106 B/C 3B. Some of the essential welding variables were checked and found to be as follows; 31.5 volts, 305 amperage and 311 millimeters per minute travel speed and preheat of 150° Celsius.

This QAI observed Certified Welding Inspector (CWI) Wang Nam in Bay 3 checking the heating parameters for heat straightening of BP012-01-013 using HS (B) 010.

Summary of Conversations:

No conversations held today.

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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer