

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-001203**Date Inspected:** 07-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hue Wei Qing, Sha Zhi & Xu Le			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 & 89 Meter Mock-Up		

Summary of Items Observed:

OBG

This Quality Assurance Inspector observed in bay 3, Zhenhua Port Machinery Company welder Sun Tiyu, welder identification 054459 welding a stiffener using the flux core arc welding process on side plate weld joint SP048-01-23. The amperage was found to be 275 and the voltage 28.5. Welder Wang Zhong Hua, welder identification 053753 was tack welding with the shield metal arc welding process on side plate weld joints SP003-01-015 & 016. Fillet welding was also observed on the gantry on side plate SP013-01 where the voltage was found to average between 29 & 30, the amperage 299 & 310, the preheat was 60° Celsius and the travel speed was recorded at 450 millimeters per minute. The Certified Welding Inspector on the floor was Wu Ming Kat.

This Quality Assurance Inspector observed in bay 7, Zhenhua Port Machinery Company Welder Wang Changfa, welder identification 058102 welding on floor beam weld joint FB004-02-007. The essential welding variables were checked and the voltage was found to be 22, the amperage 160, the preheat 28° Celsius and the travel speed 95 millimeters per minute. The Certified Welding Inspector for Zhenhua Port Machinery Company was Zhang Zhong.

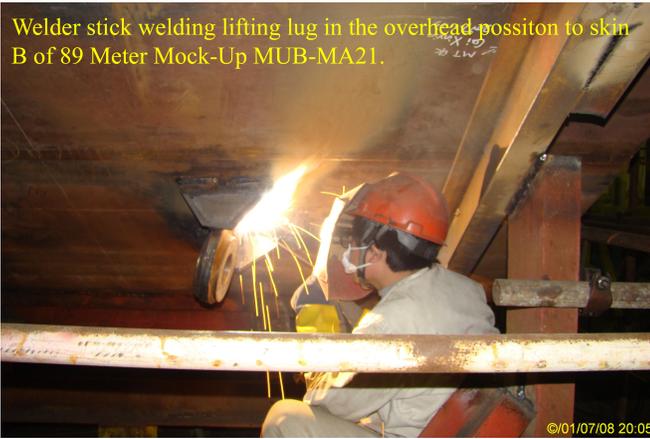
89 Meter Mock-Up

This Quality Assurance Inspector observed in bay 2 on MUB-MA21 a lifting lug being welded with the shield metal arc welding process on skin plate B in the overhead position and Gong Hai gang, welder identification 037840 welding weld joint #56 with the shield metal arc welding process. The essential welding variables were

WELDING INSPECTION REPORT

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checked and the voltage was found to be 24.6, the amperage 216 and the travel speed 118 millimeters per minute.



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 for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer
