

**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-001225**Date Inspected:** 14-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Hu Wen Qing			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Floor Beams		

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Bay 7: The QA inspector made random observations of welding in progress on floor beam assemblies.

The QA Inspector witnessed ZPMC welder Wang Min certification number 048296 depositing filler metal on a Complete Joint Penetration (CJP) weld on floor beam FB026-01-117 and 122 on the b side of the plate, utilizing the Submerged Arc Welding (SAW) process using welding procedure WPS-B-T-2221-B-L2C-S-1. ZPMC Certified Welding Inspector (CWI) Hu Wen Qing Certification Number 04062001 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 530, Volts 30, Travel Speed 435mm/minute, temperature 100°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, and appear to comply with approved WPS.

The QA Inspector witnessed ZPMC welder Wang Min certification number 048296 depositing filler metal on a Complete Joint Penetration (CJP) weld on floor beam FB018-01-117 and 122 on the b side of the plate, utilizing the Submerged Arc Welding (SAW) process using welding procedure WPS-B-T-2221-B-L2C-S-1. ZPMC Certified Welding Inspector (CWI) Hu Wen Qing Certification Number 04062001 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 530, Volts 30, Travel Speed 435mm/minute, temperature 111°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, and appear to comply with approved WPS.

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# WELDING INSPECTION REPORT

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The QA Inspector witnessed ZPMC welder Wang Min certification number 048296 depositing filler metal on a Complete Joint Penetration (CJP) weld on floor beam FB025-01-117 and 122 on the b side of the plate, utilizing the Submerged Arc Welding (SAW) process using welding procedure WPS-B-T-2221-B-L2C-S-1. ZPMC Certified Welding Inspector (CWI) Hu Wen Qing Certification Number 04062001 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 530, Volts 30, Travel Speed 435mm/minute, temperature 110°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, appear to comply with approved WPS.

### Summary of Conversations:

No relevant conversations spoken on this date.

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

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