

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001272**Date Inspected:** 18-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**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 fit up, 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 77M Diaphragm Assembly			In Progress

ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Zhu Zhong Hai was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed SMAW in progress of fill passes on 77m tower p1124 to SA104 weld joint MUSA-MA-SA104 A/B 58 and p582 to SA95 weld joint MUSA-MA-SA95 58. The weld joints Complete Joint Penetration welds in the 3G position. The approved welders Zhai Qingshan # 058026 and Yang Lei # 040690 were using approved welding procedure specification WPS-B-T-3213-B-U2a. Caltrans QA Inspector verified welding parameters at 189, 185 amps, 24.3, 25 volts and 115, 120 millimeters per minute (mm/min) travel speed. Preheat and interpass 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 E9018 H4R 4mm in diameter. An electrode oven was observed by Caltrans QA Inspector in use during the welding process.

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

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: Hernandez, Dan

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer