

**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-001324**Date Inspected:** 20-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Wu Ming Kai	<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 Beam	

**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.

Welding was being performed on FB022-2 by ZPMC welder Huong Xin Lan certification number 044780 certified for Submerged Arc Welding (SAW) in the 1G position was observed welding filler passes while utilizing welding wire Jin-3 (0.48mm/dia.)/JF-3. The procedure used was WPS-B-T-2221-B-L2C-S-1 and the welding parameters recorded by this QA Inspector were, Amps 525, 530 & 532, Volts 30 & 31, Temperature 87C, 91C & 117C and the Travel Speed was measured to be 435mm/min. The ZPMC CWI present was Wu Ming Kai and the ZPMC QC was Xiang Feng Feng.

**Summary of Conversations:**

No conversations spoken.

**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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# WELDING INSPECTION REPORT

*( Continued Page 2 of 2 )*

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