

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-001426**Date Inspected:** 27-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Zhong**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**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 7- QA Inspector randomly observed ZPMC qualified welder Ma Mingfu ID #056375 utilizing the Shielded Metal Arc Welding (SMAW) process per the approved Welding Repair Procedure #B-WR052 and Welding Procedure Specification (WPS) number WPS-345-SMAW-2G(2F) Repair while performing weld repairs to Floor Beam FB2. QA Inspector observed that repair welding on FB2 at weld joint FB002-03-011 was monitored by QC Inspector Zhang Zhong. QA Inspector observed welding and preheating parameters are within the parameters of the WPS and recorded them as follows: welding amperage 167 amps, welding voltage 24 volts. Preheat temperature is verified by QA Inspector at 72° Celsius prior to welding. The weld parameters appeared to comply with contract requirements and the approved WPS.

Bay 7- QA Inspector Gabriel Quintana performed numerous measurements on fourteen Floor Beams as requested by the Engineer. QA Inspector Paul Dawson recorded these measurements performed by QA Inspector Gabriel Quintana. Measurements of the stiffeners included weld hold back at the weld terminations and snipe hole dimensions. The data collected when complete will be forwarded to the requesting Engineer.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

General communications took place between the QA and QC Inspector.

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:	Quintana, Gabriel	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Cochran, Jim	QA Reviewer
---------------------	--------------	-------------