

**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-001613**Date Inspected:** 22-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:** Hu Wei Qing**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 Wang Changfa ID #058102 utilizing the Shielded Metal Arc Welding (SMAW) process per the approved Welding Procedure Specification (WPS) number WPS-B-T-2113 while tack welding stiffeners to Floor Beam Assembly at weld joints FB003-02-014, FB003-02-024 and FB003-02-026. The QA Inspector randomly monitored weld parameters and recorded them as follows: preheat temperature 78° Celsius, welding amperage 154 amps. Welding is observed by QC Inspector Hu Wei Qing. QA observations and weld parameters appeared to comply with contract requirements and the approved WPS.

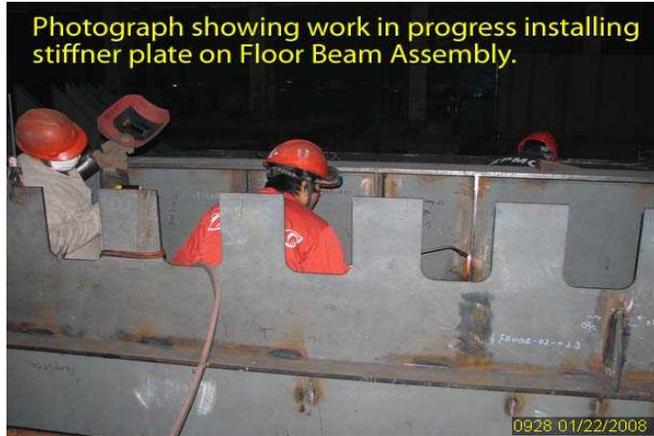
Bay 7- QA Inspector is in progress performing an Ultrasonic Test (UT) inspection to determine if indication located in the weld toe of Floor Beam Weld FB017-02-101 is caused by defects in the weld or are a result of weld joint geometry. QA Inspector observed an indication located in the second leg using a 70 degree inspection angle. Weld reinforcement was ground flush to the parent material in a location directed by the QA Inspector. QA Inspector observed that grinding the weld location flush did not have a significant reduction of amplitude from the indication. At this time, QA Inspector has not determined the cause of the indication and further evaluation is required.

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# WELDING INSPECTION REPORT

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## 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.

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<b>Inspected By:</b>	Quintana, Gabriel	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran, Jim	QA Reviewer

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