

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-001518**Date Inspected:** 18-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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:** 89M Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for 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 corner plate	NA	NA	welding in progress

89M Mock-Up: Caltrans QA Inspector observed flux cored arc welding (FCAW) complete joint penetration (CJP) welding in progress in the New Tower Shop. The assembly is identified as SA184 – SA194 (MUB-MA21 J/J-20). The welder is identified as Mr. Pan Meng, welder #66673, welding in the 3G (vertical position). The welder is using welding procedure specification WPS-B-T2233-B-U2a-F, Revision 0. Caltrans QA Inspector measured current welding parameters at approximately 210 amps, 26.5 volts and 112 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. The preheat temperature prior to the start of welding measures more than 110 Celsius (230 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. FCAW welding consumable is verified and identified as Supercored 71H, classification E71T-1, diameter 1.4 mm (.055 inches). Caltrans QA observed ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi monitoring welding activities at the workstation. The following digital pictures illustrate welding in progress.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

At 1930 hours, QA was contacted by Mr. Jimmy Cochran. Mr. Cochran requested that QA document, deck plane DP058 u-rib U131 and DP015 u-rib 133 lengths and submit information to Mr. Ady Velasco for review.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
