

**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-001522**Date Inspected:** 25-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Ping, C M Chen**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 (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 Floor beams			in progress
<p>ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Huang Wen Ping was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of tack welds on stiffener plates to floor beam FB-021-02, welding was performed in the 2G position. The approved welder Hong Shuili # 044815 is using approved welding procedure specification WPS-B-T-2132-3. Caltrans QA Inspector observed CWI verify welding parameters, approximately 301 amps and 29 volts. Preheat temperatures were verified during welding activities and were within approved WPS minimum and maximum range. FCAW welding consumable is verified and identified as classification Supercored 71H E71T-1 1.4mm in diameter.</p>			

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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2 OBG Bottom Plate in progress

ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. C M Chen was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed FCAW in progress of fillet welds on six T stiffener plates to bottom plate BP-015-001 welds 15 – 24. The T joint fillet welds were welded in the 2G position. Welding was performed with the use of a Gantry. The approved welders # 058174, 054459 and 048801 were using approved welding procedure specification WPS-B-T-2132-3. Caltrans QA Inspector observed CWI verify welding parameters, approximately 300 amps, 30 volts and 446 millimeters per minute (mm/min) travel speed. Preheat temperatures were verified during welding activities and were within approved WPS minimum and maximum range. FCAW welding consumable is verified and identified as classification Supercored 71H E71T-1 1.4mm in diameter.



## 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.

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**Inspected By:** Hernandez, Dan

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Reviewed By:** Cuellar,Robert

QA Reviewer