

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-001656**Date Inspected:** 12-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:** Fu Yu Hong**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 Deck panels and Tower Mock-up**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector observed welding operator Hang Chang Hou welding the filler passes on the deck panel splices at the weld joint DP-002-022-009 following the approved welding procedure specification WPS-B-T-2221-B-L2C-S-1. Base metal was designated as A-709 Grade 50. ZPMC was using the submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter electrode designated as EM12K/AWS A5.17, brand name JW-3. The QA Inspector verified amperage, voltages, travel speed, preheat and heat interpass temperatures. The QA inspector found that the welding parameters recorded after ZPMC approved Certified Welder Inspector Chen Shigong appeared to be in accordance with the contract documents.

The QA observed that ZPMC was performing cutting operations with oxyfuel gas cutting process on the Tower diaphragms plates A-5-1, P22-1, A7-1.

The QA inspector performed random dimensional inspection to the U-rib U-191. The QA inspector found that dimensional appeared to be in accordance with the contract documents.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

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

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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