

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-002005**Date Inspected:** 17-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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:** Tower**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, Orthotropic Box Girders (OBG) and Tower, 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 Tower Skin Plate	NA	NA	Welding

New Tower Shop Bay 2: ZPMC performed submerged arc welding (SAW), tower skin plate splice weld, joining plate P1303-1 (E) to P1318 (E) plate. The welder operator is identified as Mr. Xu Yian, welder stamp 040634, utilizing welding procedure WPS-B-T-2221-B-U3c-S; weld joint ESD1-SA216 A/K- 16B. Caltrans QA measured current welding parameters at approximately 660 amps, 33.0 volts and 590mm/min (millimeters per minute) travel speed.

Caltrans QA verified preheat and interpass temperatures during the welding activities. The preheat temperature prior to the start of welding measures more than 110 degrees Celsius but less than 230 degrees Celsius during maximum interpass temperature verification. Caltrans QA observed ZPMC QC inspector, Mr. An Qing Xiang and ABF Inspector, Mr. Li Han jie monitoring welding activities at the work station. The following digital picture illustrates welding in progress.

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- 2 Tower Small Parts NA NA Flame Cut Parts
New Tower Shop Bay 1: Caltrans QA observed ZPMC shop worker flame cutting nested parts at the burn table for tower subassemblies identified as P229, P222 and P4. The following digital picture illustrates nested parts.



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.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer