

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-002199**Date Inspected:** 03-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhao Chen Sun, Wang Sai Fa	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:

This Quality Assurance Inspector (QAI) observed welding in Bay 4 by Zhenhua Port Machinery Company (ZPMC) welder Gu Cai Hong, welder identification 053748 on weld joint WSD1-SA27 A/B-1 side B with the submerged arc welding (SAW) process. Some of the essential welding variables observed and recorded were; amperage 630, voltage 30, travel speed 480 millimeters per minute and preheat temperature 200° Celsius.

This QAI observed welding in Bay 4 by ZPMC welder Jiang Jing Teng, welder identification 046830 on weld joint WSD1-SA268-16 side B with the submerged arc welding (SAW) process. Some of the essential welding variables observed and recorded were; amperage 626, voltage 30, travel speed 492 millimeters per minute and preheat temperature 200° Celsius.

This QAI observed tack welding in Bay 7 by ZPMC welder Wang Chang Fa, welder identification 058102 on stiffener welds of FB003-028 with the shield metal arc welding (SMAW) process.

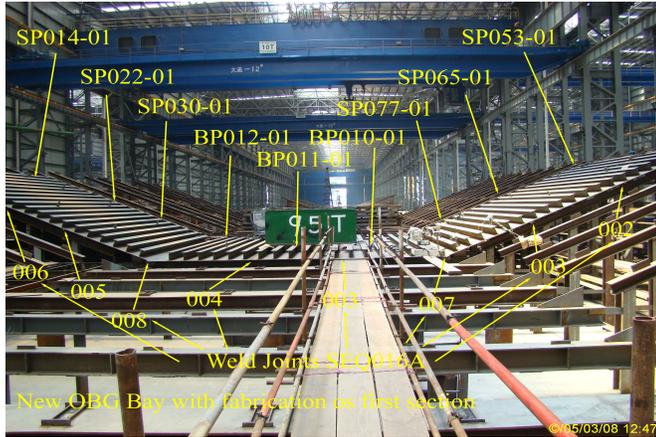
This QAI observed tack welding in Bay 7 by ZPMC welder Wu Wan Yong, welder identification 050242 on stiffener welds of FB003-047 with the flux core arc welding (FCAW) process. Some of the essential welding variables observed and recorded were; amperage 206, voltage 25.7, travel speed 114 millimeters per minute and preheat temperature 28° Celsius.

This QAI observed tack welding in Bay 7 by ZPMC welder Sun Gu Zoo, welder identification 058100 on stiffener welds of FB012-009-023 with the SAW process. Some of the essential welding variables observed and recorded were; amperage 500, voltage 30.5, travel speed 430 millimeters per minute and preheat temperature 81° Celsius.

WELDING INSPECTION REPORT

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This QAI observed welding in the New Orthotropic Box Girder (OBG) by ZPMC welder Xang Wei, welder identification 066413 on weld joint SEQ016A-007 with the SAW process. Some of the essential welding variables observed and recorded were; amperage 640, voltage 33 and travel speed 560 millimeters per minute.



Summary of Conversations:

No conversations held today.

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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
