

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000833**Date Inspected:** 09-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Sha Zhi & Li Wen Sheng (BV)			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:	89 Mock-Up		

Summary of Items Observed:

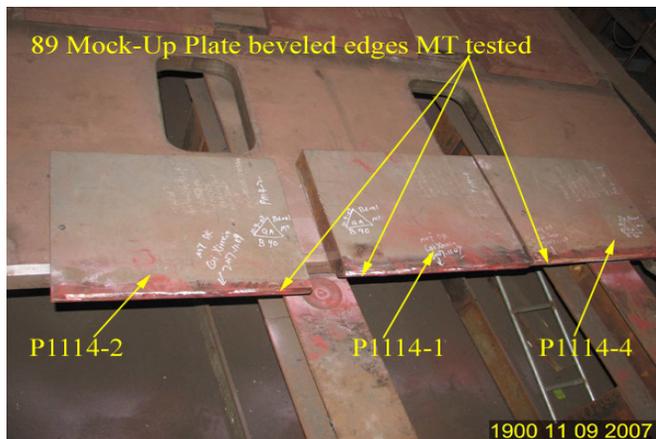
On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up Strut Assembly Magnetic Particle (MT) testing of plate bevel edges for the following plates that had previously been welded with the wrong welding rods causing an NCR #003 to have been written: P1114-1 (26-1), P1114-2 (26-2) & P1114-4 (26-4 having a thickness of 75mm and MP517-2 (CWR019), MP517-3 (CWR22) & MP517-4 (CWR20) which was 45mm thick. The beveled edges for each of the plates listed were MT tested by this Caltrans QA Inspector and found to be in compliance with the project specifications.

Item-2 77 Diaphragm Flange Plate Reinforcement Ring. Welding of the filler passes was in progress for the flange reinforcement ring to diaphragm plate by Zhenhua Port Machinery Company (ZPMC) welders (A) Liu Wei #048532 and (B) Zhai Qingshan # 058026 certified for Shielded Metal Arc Welding in the 3G position. The welding procedure used was MPS-B-T-4112-3 and the material was 345 to 485 material, plate MUSA-SA104. Welding parameters recorded for each welder by this QA Inspector were, welder (A) Amps 213, Volts 23.5, Travel Speed (T/S) 112mm/min., Temperature 180c and welder (B) Amps 219, Volts 24, T/S 120mm/min. & Temperature 170c.

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer