

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000844**Date Inspected:** 11-Nov-2007**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:** Changxing Island**CWI Name:** Fu Guo Gan**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:** Mock-up # 114**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Welding and Magnetic Particle Testing (MT) of the Caltrans Mock-up # 114.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector witnessed ZPMC QC Mr. Cai Xin Xin performing MT of Mock-up # 114.00 Skin Plate C splice welds # 2 and 4. Mr. Cai Xin Xin also performed MT of bottom diaphragm flange section SA 274 bevel face after Mock-up 114.00 Skin Plate C longitudinal stiffener welds 6, 7, 9, 10, 12 and 13. The welds were reported to be acceptable by Mr. Cai. Caltrans QA Inspector Viars performed MT of the above mentioned welds. See MT report TL6028, generated on this date for further information.

Caltrans QA Inspector Viars observed ZPMC personnel prepping Orthotropic Box Girder Closed rib weld trial # 3 deck plate for welding. The attached photo below shows ZPMC personnel prepping welding the welding surface. Caltrans QA Inspector Viars observed ZPMC welder Mr. Tao Qian performing Flux Cored Arc Welding (FCAW) on weld # 4 of Mock-up # 114.00 interior splice plate assembly A75. The following welding parameters were recorded, amperage 290, voltage 30.0, welding travel speed 295 mm/min. and a heat input of 1.76 kJ/mm.

The Caltrans QA Inspector observed MT and the welding of the above mentioned items appeared to be in general conformance with AWS D1.5 2002 requirements.

WELDING INSPECTION REPORT

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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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
