

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-000868**Date Inspected:** 19-Nov-2007**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:** Chen Xi**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 Mock Up**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the fabrication of the Tower Mock Up.

Bay 2:

Elevation 77M:

The QA Inspector randomly observed ZPMC welder Li Zhangxu ID Number 066179, utilizing the Shielded Metal Arc Welding (SMAW) Process with approved ZPMC Weld Procedure Specification (WPS) WPS-B-T-3313-TC-P5 in the 3G position at web to web Weld Joint (WJ) MUA-MA1-D/F-4, on 77M Diaphragm Assembly MUSA-SA95/SA104. The QA Inspector observed ZPMC CWI Chen Xi monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows: welding amperage 167 amps, welding voltage 23.5 volts with a travel speed of 90 millimeters per minute. Weld parameters appeared to comply with the above approved ZPMC WPS. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Xu Changxue ID Number 066002, utilizing the Shielded Metal Arc Welding (SMAW) Process with approved ZPMC Weld Procedure Specification (WPS) WPS-B-T-3313-TC-P5 in the 3G position at web to web Weld Joint (WJ) MUA-MA1-D/F-6, on 77M Diaphragm Assembly MUSA-SA95/SA104. The QA Inspector observed ZPMC CWI Chen Xi monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows:

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welding amperage 174 amps, welding voltage 24.8 volts with a travel speed of 96 millimeters per minute. Weld parameters appeared to comply with the above approved ZPMC WPS. The attached photograph provides additional detail.



Summary of Conversations:

There were no relevant conversations.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer