

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-000935**Date Inspected:** 22-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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:** Sha ZHI**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:** CalTrans mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fitup, welding and related activities associated with the fabrication of 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 89M Strut Assembly			In Progress

Caltrans QA Inspector observed SMAW in progress of fill passes on strut web connection plates P913-3 to SA24-3 and P913-4 to SA24-4. The weld joint is a Complete Joint Penetration (CJP) double bevel T-joint in the 1G position. The approved welders Dai Lu # 048659 and Wang Zhon Hua #053753 were using approved welding procedure specification WPS-B-T-3211-TC-U5B. Caltrans QA Inspector observed welding parameters at approximately 278, 285 amps, 23.5, 24.2 volts and 166, 152 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SMAW welding consumable is verified and identified as classification E9018 H4R Excalibur 4mm diameter. An electrode oven was observed by Caltrans QA Inspector in use during the welding process. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi and Bureau Veritas Inspector Mr. Hua Li Wei were observed monitoring welding activities at the workstation.

WELDING INSPECTION REPORT

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Summary of 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:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
