

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-000965**Date Inspected:** 30-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Fu Guo Gang	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:	77, 89 & 114 Meter Mock-Up	

Summary of Items Observed:

Mock-Up 77

This Quality Assurance Inspector performed magnetic particle testing of an excavation on MUSA MA2 weld 2 for CWR002R1. The excavation was approximately 150 millimeters in length, 50 millimeters in width and 30 millimeters in depth. For details of the magnetic particle testing see TL 6028 dated November 30, 2007.

Mock-Up 89

This Quality Assurance Inspector witnessed ZPMC magnetic particle technician Cai Xinxin performing magnetic particle testing of the ends of the welds for MUSB-MA26-27A/B; 27A-1/B-1; 10A/B; 9A-1/B-1; 10A-1/B-1; 9A;9B & MUSB-MA25-6A/6B. This Quality Assurance Inspector performed 10% verification testing on MUSB-MA26-9A and 10B which included the 100% of the weld cover passes and both ends of the welds where run off tabs had been removed. For details of the magnetic particle testing see TL 6028 dated November 30, 2007.

Cross Brace Sub-Assembly on welds 13, 14, 15 & 16. This Quality Assurance Inspector also performed 10% verification testing on these welds. For details of the magnetic particle testing see TL 6028 dated November 30, 2007.

This Quality Assurance Inspector performed magnetic particle testing of a root welds on MUSB-MA22 partial penetration weld joints 7 & 8 for the longitudinal stiffener plate mp537a to skin plate D MA22. For details of the magnetic particle testing see TL 6028 dated November 30, 2007.

WELDING INSPECTION REPORT

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This Quality Assurance Inspector witnessed ZPMC magnetic particle technician Cai Xinxin performing magnetic particle testing of the tack welds for MUSB-MA29 Cross Brace Sub-Assembly on welds 13, 14, 15 & 16. This Quality Assurance Inspector also performed 10% verification testing on these welds. For details of the magnetic particle testing see TL 6028 dated November 30, 2007.

Mock-Up 114

This Quality Assurance Inspector observed ZMPC welder Chang Chuancang, welder identification 053870 welding on MUSC-MA113-11 CWR-008-R1 in the flat position. Some of the essential welding variables were checked and found the voltage to be 31.2, amperage 320 and the travel speed 297 millimeter 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:	Cochran, Jim	QA Reviewer
