

**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-000995**Date Inspected:** 03-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**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:** Xu Lefeng**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 fit up, 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 Skin Plate E			In Progress

Caltrans QA Inspector observed flux cored arc welding (FCAW) in progress of longitudinal stiffener plate mp544 and mp530 to skin plate E. The weld joints are Partial Joint Penetration (PJP), double bevel T-joints. The welder was observed welding filler passes in the 1G position using a chipping hammer and wire brushing during interpass weld cleaning. The approved welder is identified as Mr. Li Shu Qiang # 053609 using welding procedure specification WPS-B-T-2231-TC-P5-F1. Caltrans QA measured current welding parameters at approximately 302 amps, 31 volts and 288 millimeters per minute (mm/min). Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum and maximum range. FCAW welding consumable is verified and identified as Supercored 71H, classification E71T-1, diameter 1.4 mm (.055 inches). ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Xu Lefeng was observed monitoring welding activities at the workstation.

**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

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## WELDING INSPECTION REPORT

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for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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