

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-001040**Date Inspected:** 19-Dec-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:** Caltrans Mock-Up**Summary of Items Observed:**

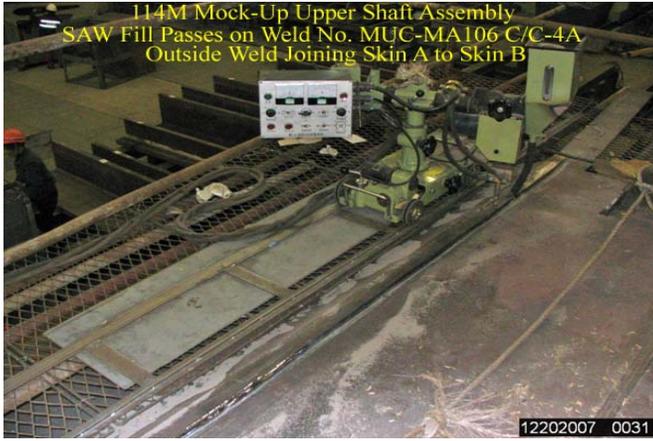
Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

The Caltrans QA Inspector observed that two weld passes using Machine Submerged Arc Welding (SAW) had been made on Upper Shaft Assembly on the 114M Mock-Up, Weld No. MUC-MA106 C/C-4A. This is the outside weld of Skin A to Skin B. This is a complete joint penetration (CJP) weld and was welded in the flat groove (1G) welding position. The welder was Xu Yan (I.D. No. 052917), whose qualifications for this welding are listed in ZPMC's Master List of Welders/Welding Operators/Tack Welders, Revision 7. Welding Procedure Specification (WPS) WPS-B-T-2221-C-U2b-S was being used for this weld. ZPMC CWI, Chen Xi (CWI No. 07072021) was present during welding as was Bureau Veritas Inspector, Li Wen Shang. The QA Inspector also noted that ZPMC's documentation of minimum/maximum preheat/interpass temperatures, voltage, amperage and travel speed by Chen Xi were within the specified ranges of the WPS for the two passes.

All observations appeared to meet the requirements of the job specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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: Jobs, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer