

**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-001226**Date Inspected:** 12-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Cui Yi Ru**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:** Floor Beams**Summary of Items Observed:**

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

Bay 7: The QA inspector made random observations of welding in progress on floor beam assemblies.

The QA Inspector witnessed ZPMC welder Yuan Wen Song certification number 055491 depositing filler metal on the root pass of floor beam FB026-01-117 and FB026-01-122 utilizing the Flux Cored Arc Welding (FCAW) process using welding procedure WPS-B-T-2231-B-U2-F-1. ZPMC Certified Welding Inspector (CWI) Cui Yi Ru Certification Number 00072221 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 279, Volts 30, Travel Speed 510mm/minute, temperature 124°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, and appear to comply with approved WPS.

The QA Inspector witnessed ZPMC welder Huang Xin Lun certification number 044780 depositing filler metal on floor beam FB022-01-081 utilizing the Submerged Arc Welding (SAW) process using welding procedure WPS-B-T-2221-B-L2C-S-1. ZPMC Certified Welding Inspector (CWI) Cui Yi Ru Certification Number 00072221 and ZPMC Quality Control Inspector (QC) Zhu Tian Shu was observed monitoring and recording the following weld parameters Amperage 532, Volts 30, Travel Speed 440mm/minute, temperature 85°C. The QA inspector also monitored welding parameters and the findings concur with ZPMC CWI and QC's results, appear to comply with approved WPS.

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# WELDING INSPECTION REPORT

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**Summary of Conversations:**

No relevant conversations spoken on this date.

**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.

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

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