

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-001268**Date Inspected:** 21-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**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 77M Diaphragm Assembly			In Progress

ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Zhu Zhong Hai was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed FCAW in progress of fill passes on 77m Diaphragm Assembly, weld joint MUA-MA1 F/F 15 and MUA-MA1 F/F 22. The weld joints were Complete Joint Penetration welds in the 3G and 2G position. The approved welders Wang Bing # 048696 and Kong Shengli # 066002 were using approved welding procedure specification WPS-B-T-2233-B-U2a-F and WPS-B-T-2332-TC-P4-F. Caltrans QA Inspector observed QC Zhu Zhong Hai verify welding parameters. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. FCAW welding consumable is verified and identified as classification Supercored 71H 1.4mm in diameter.

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.

WELDING INSPECTION REPORT

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