

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001274**Date Inspected:** 14-Jan-2008**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:** Sha Zhi**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:**

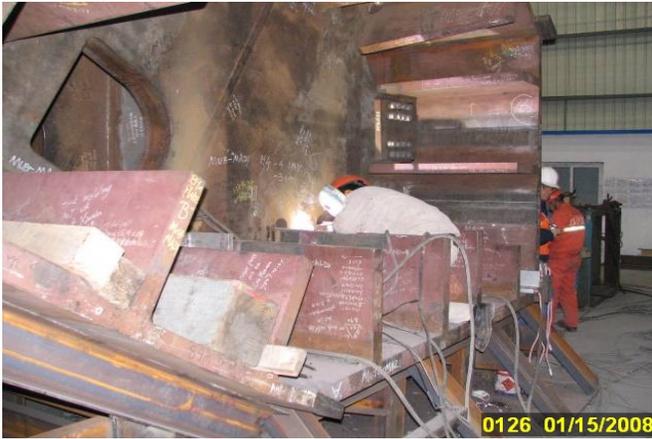
Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 89 Meter tower mock up			In Progress

Caltrans QA Inspector observed SMAW in progress of fill passes on 89m mock up assembly weld joints mub-ma21 A/J 13 and 14 and mub-ma21 G/J 13 and 14 of musb-ma21 to SA13 and P213. The weld joints are T-joint fillet welds in the 3F position. The approved welders Tan Xiaobo # 066459 and Xu Chang Xue #066002 were using approved welding procedure specification WPS-B-P-2113. Caltrans QA Inspector observed welding parameters at approximately 142 amps, 23.2 volts and 96 millimeters per minute (mm/min) travel speed for welder #066002. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SMAW welding consumable is verified and identified as classification E7018. An electrode oven was observed by Caltrans QA Inspector in use during the welding process. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi was observed monitoring welding activities at the workstation.

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: Hernandez, Dan

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer