

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-001297**Date Inspected:** 14-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**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:** 89 & 77 Meter Mock Up**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

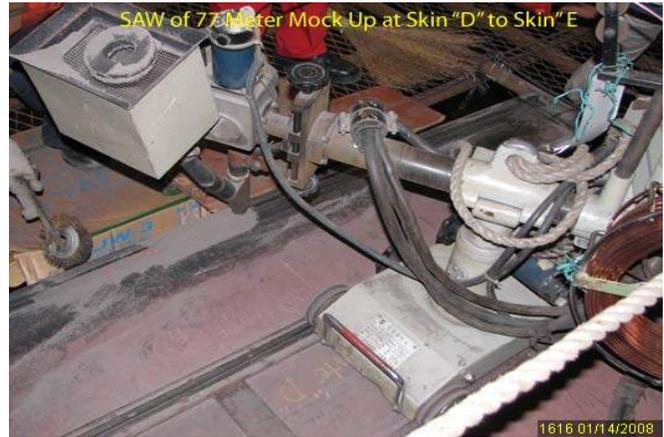
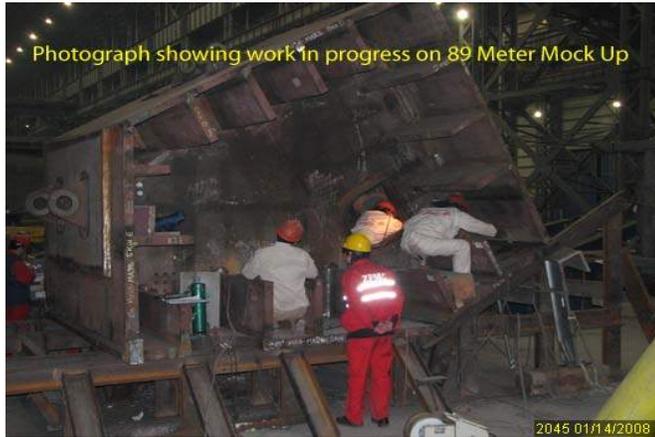
Bay 2- QA Inspector observed ZPMC qualified welder Xue Yian ID #040634 groove welding fill passes on the 77 Meter Mockup MAU-MA1-D/F joining Piece Mark MA5-1 to Piece Mark MA1-1, Skin "D" to Skin "E" at weld joint number 17B. QA Inspector observed QC Inspector Xu Le Feng observing welding in the 1G (flat) position utilizing the Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand JW-3, class EM12K per WPS-B-T-2221-C-U2b-S. QA Inspector observed QC Inspector perform frequent monitoring of preheat and interpass temperature. QA Inspector observed that the welding parameters and preheat are in accordance with the approved WPS and verified the following welding parameters: interpass 195° Celsius, 730 amps, 33 volts and travel speed of 730 mm per minute. QA observations appear to comply with contract requirements and the approved WPS.

Tower Shop - QA Inspector observed ZPMC qualified welders Xu Changxue ID #066002 and Tan Xiangbo ID #066459 groove welding fill passes at weld joint MUB MA21 A/J-11 on the 89 Meter Mockup per the Welding Procedure Specification (WPS) B-T-2113. QA Inspector observed that Li Mengqian ID #054460 and Li Zhaoqian ID #048810 are in progress performing welding using the Flux Core Arc Welding (FCAW) process per the approved welding procedure WPS-B-T-2232-TC-U5-F at weld joint MUB MA21 D/7-3A. QA Inspector observed

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that welding parameters were monitored by ZPMC QC Inspector Sha Zhi and appeared to comply with contract requirements and the approved WPS.



Summary of Conversations:

General communications took place between the QA and QC Inspector.

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: Quintana, Gabriel

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer