

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-001345**Date Inspected:** 30-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Huwei Qing**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:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual observations and monitor welding operations of the 77 meter mock-up Orthotropic Box Girder (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars observed ZPMC welder Mr. Li Shuliang performing semi automatic Flux Cored Arc Welding (FCAW) with the Gantry machine in the 2G position on Side Plate SP054-01-016. ZPMC QC Mr. Huwei Qing (Lead CWI) monitored welding operations. Welding appeared to meet the requirements of the posted Welding Procedure Specification, WPS-B-T-2132-3. The following welding variables were recorded, amperage 310 voltage 29.3, travel speed 446 mm/min. and a heat input of 1.22 Kj/mm.

Caltrans QA Inspector Viars observed ZPMC QC performing heat straightening on Bottom plate BP004 (3AE). ZPMC provided Heat Straightening Record, HSR 1(B)-164 for review. The maximum deformation before heat straightening recorded by ZPMC was 22mm.

Summary of Conversations:

No relevant conversations occurred 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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