

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-001349**Date Inspected:** 24-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island

CWI Name:	Wu Ming Kai			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:	77 & OBG		

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual observations, Magnetic particle Testing (MT) and monitor welding operations of the 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 welders Mr. Sun Tiyu, Mr. Dong Jinbao and Mr. Xin Meng performing semi automatic Flux Cored Arc Welding (FCAW) with the Gantry machine in the 2G position. Each welder controlled two welding heads. 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 280, voltage 30.0, travel speed 475 mm/min. and a heat input of 1.06 Kj/mm.

Caltrans QA Inspector Viars observed ZPMC welder Mr. Li Xuehua performing FCAW welding on Bottom Plate BP024, weld # BP024-01016. Welding appeared to be in conformance with the posted WPS.

Caltrans QA Inspector Viars observed ZPMC personnel performing heat straightening of 33 meter diaphragm plates SA261, Heat Straightening Record (HSR1 (T) -13) and P540 (HSR1 (T) -010).

Caltrans QA Inspector Viars performed MT of the 77 meter mock-up diagonal corner insert plate welds SA104 # 9, 10 and 11. Please see MT report TL-6028, generated on this date for further information. The digital picture below shows access of the above mentioned welds.

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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.

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