

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-001363**Date Inspected:** 28-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wu Meng Kai & Hu Wei 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:

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, and Joe Lanz performing fabrication inspection out on the shop floor today.

Mr. Stovall observed welding and other various fabrication operations in bay 2 where the welders were working on the 89 & 114 Meter Mock-Up.

OBG

This Quality Assurance Inspector observed Zhenhua Port Machinery Company (ZPMC) welder Zhang Feng, welder identification 049769 welding with the shield metal arc welding process on weld SP001-01-007 using welding procedure specification WPS-B-P-2112-FCM. Some of the essential welding variable were checked and found to be 177 for the amperage; 23.1 for the voltage; 107 millimeters per minute for the travel speed and 79° Celsius for the preheat.

This Quality Assurance Inspector observed ZPMC welder Yuan Won Song, welder identification 055491 welding with the flux cored arc welding process on weld FB001-04-003 using welding procedure specification WPS-B-T-2132-3 in the horizontal fillet welding position. Essential variables were checked and found the amperage to be 297, the voltage to be 29.8 and the travel speed to be 461 millimeters per minute.

Summary of Conversations:

No conversations held today.

Comments

WELDING INSPECTION REPORT

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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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
