

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-001465**Date Inspected:** 20-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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.

89m Tower Mock Up

ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of fill passes on 89m Tower Mock Up corner connection plate MA39 to MUSB-MA23 Skin C. Weld joint MUB-M21 J/J 47 is a Partial Joint Penetration T joint welded in the 2G position. The approved welder Lei Li Chao # 053619 is using approved welding procedure specification WPS-B-T-2332-TC-P4-F. Caltrans QA Inspector verified welding parameters at approximately 326 amps, 31 volts and 316 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum and maximum range. FCAW welding consumable is verified and identified as classification Supercored 71H 1.4mm in diameter.

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

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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