

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-001584**Date Inspected:** 11-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:	Li Zhi Jiang, 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:	OBG Mock-Up	

Summary of Items Observed:

This Quality Assurance Inspector (QAI) observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California

This QAI observed Quality Control Inspector (QCI) Duan Ya Bing in Bay 3 checking the heating parameters for heat straightening of SP022-01-13 24 using HS (B) 063. Duan Ya Bing's name does not appear on the approved Certified Welding Inspector (CWI) & Certified Associated Welding Inspector (CAWI) List dated 09/18/2007.

This QAI observed ZPMC welders Li Shu Liang, welder identification 048801, Xin Meng, welder identification 053742 and Li Zhao Qian welder identification 048810 welding on side plate SP075-001. ZPMC CWI Wu Ming Kai was observed checking and recording welding parameters.

This QAI observed ZPMC welder Han Jian She, welder identification 066458 tack welding in the horizontal position with the shield metal arc welding (SMAW) process on side plates SP039-01-013 & 014. The amperage was checked and found to be 178 and the preheat temperature was 70° Celsius.

This QAI reviewed the radiographic film quality and welds for 20 millimeter thick bottom plate splice weld for BP001-01-001 & BP003-01-001 along with the 14 millimeter splice weld for MU1-1-11. For details see radiographic report TL-6028 dated December 11, 2007.

Summary of Conversations:

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No conversations held today.

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