

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-001652**Date Inspected:** 29-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Sun Wei**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 Deck Panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform observations of the welding of Orthotropic Box Girder (OBG) Deck Panel Production, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

The Caltrans QA Inspector observed ZPMC welders Mr. Shi Yunli and Mr. Hao Long performing Gas Metal Arc Welding (GMAW) on Deck Panel DP016-001 U-rib tack welds. The following welding variables were recorded, amperage 336, voltage 31.1, travel speed of 540 with a heat input of 1.16 kJ/mm. Welding appeared to be in conformance with WPS-B-T-2342-U2 (u-rib).

The Caltrans QA Inspector observed ZPMC welder Mr. Dong Yi Qun performing Flux Cored Arc Welding (FCAW) on U-rib splice weld DP008-001-008. The following welding variables were recorded, amperage 203, voltage 25.2, travel speed of 107 with a heat input of 2.85 kJ/mm. Welding appeared to be in conformance with WPS-B-T-2233-B-U2-f.

The Caltrans QA Inspector observed ZPMC personnel drilling bolt holes with magnetic base drill for U-ribs U-144, U-146 and U-147.

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

WELDING INSPECTION REPORT

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for your project.

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