

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-001679**Date Inspected:** 05-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xianping**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:** SP & FB**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Bay-2 77 Meter Mock Up Plate B Weld #23 was monitored during an MT test performed by ZPMC Cai Xin Xin. There were no relevant indications noted during these tests.

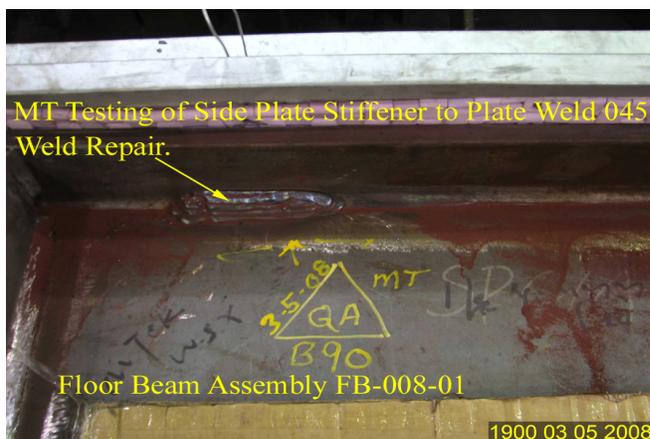
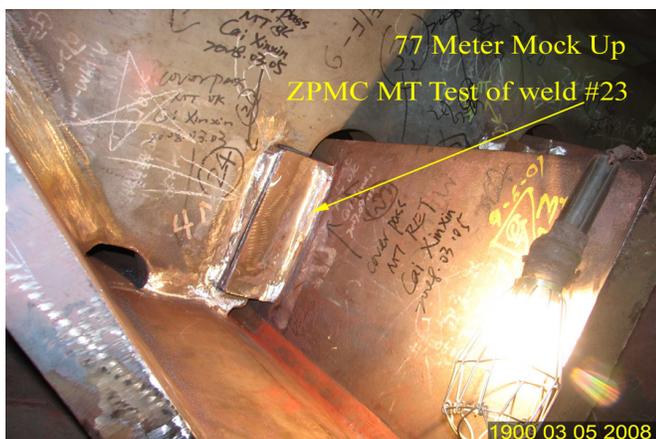
Bay-3 Side Plate SP-120-001 welds #15 & 16; 19 & 20 and 22 & 24 were in the process of being welded which would complete this assembly. The welders were Liu Zi Hong #062447 for welds 15/16 with volts of 29.6 & Amps 289, Sun Ti Yu #054459 on welds 19/20 Volts 29.2 & Amps 293 and Li Shu Hang #048801 welds 22/24 Volts 30.1 & Amps 301. Travel speed was the same, 446mm per minute, for all three welders. The CWI for this area was Xu Xianping and the welders were using WPS-B-T-2132-3 procedure.

Bay-7, Floor Plate Assembly FB-025-01 CJP weld #54 & 65 were being inspected by ZPMC QC Zhu Tian Shu.

Bay-7 Floor Plate Assembly FB-008-001 weld 45, FB-016-01-045 and FB-002-02-045 were MT tested by this Caltrans QA Inspector and were found to be in compliance with the project specifications.

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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: Smith, David

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer
