

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-001712**Date Inspected:** 28-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Huwei 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:** 89 Mock-up, OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Visual observations and monitor welding operations of the 89 meter mock-up and Orthotropic Box Girder (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars monitored Flux Cored Arc Welding of the OBG Side plate 032 stiffener tack welds. ZPMC welder Mr. He Yu Mei appeared to be welding in accordance with WPS-B-T-2132-2 and AWS D1.5 (2002) requirements. The following welding variables were recorded, amperage 272, voltage 29.3, travel speed 520 mm/min. with a heat input of 0.91 Kj/mm.

Caltrans QA Inspector Viars monitored Submerged Arc Welding (SAW) of the 89 meter mock-up Skin plate D to E Complete Joint Penetration (CJP) Weld. ZPMC welder Mr. Jiang Jingteng appeared to be welding in accordance with WPS-B-T-2221-C-U2b. ZPMC personnel were observed performing interpass cleaning and maintaining the specified temperature range. ZPMC QC Mr. Ye Yong Jun monitored welding operations. The following welding variables were recorded, amperage 687, voltage 33.8, travel speed 569 with a heat input of 2.44 Kj/mm.

The above mentioned welding appeared to meet the requirements of AWS D1.5 (2002) and contract requirements.

Summary of Conversations:

No relevant conversations occurred this date.

WELDING INSPECTION REPORT

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