

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-002033**Date Inspected:** 20-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ye Yong Jun, 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:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.). Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77-meter Mock-Up, QA Inspector observed, Z. P. M. C. Welder, Ge Hongqi--033780, welding weld number MUA-SA104-A/B-37, using Welding Procedure Specification (WPS)-B-T-4312-Tc-P4-1, weld number SA95-57, was getting ready to be started, the welders would be: Du Henghua---37779, and Wang Bing—048696.

Splice Plate, weld number MUSB-MA26-30B, was welded. Z. P. M. C., Welder, Han Xiaofeng—054467, using WPS-B-T-3312-Tc-U5B did the welding. Z. P. M. C., personnel, had stopped immediately prior to QA Inspector arriving, and did not restart while the Inspector was present.

89-meter Mock-Up, Z. P. M. C., Welder, Zi Zhaoquin—048810, Li Mengqian—054460, Lei Li Chao—053619, welded on weld number MUB-MA21-D/J-3A, using WPS-B-T-2221-c-U2b-S. This weld number is for the Skin B to Skin C weld joint. The QA Inspector checked the welding parameters and recorded the following at various times: 310 amps, 30.4 volts, 304 amps, 30.0 volts. This is within the WPS parameters.

114-meter Mock-Ups, Grinding was done on each Mock-Up, the upper and lower, on the inside diameter, on various welds, for a substantial period.

Summary of Conversations:

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No substantial conversations took place.

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:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
