

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-002110**Date Inspected:** 29-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ye Yong Jun**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**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) witnessed tack welding and back gouging in Bay 4 on the 33 Meter Bottom Diaphragm and 43 Meter Top Diaphragm. Tack welding was being carried out by Zhenhua Port Machinery Company (ZPMC) welder Lv Peng, welder identification 048617 on the 33M Btm. Diaphragm weld SA317-3 with the shield metal arc welding (SMAW) process using welding procedure specification WPS-B-T_32118-U3b-1. The weld joins the two 75 millimeter plates SA317 and p831 with a complete joint penetration (CJP) weld. Some of the essential welding variables were checked and found to be as follows; amperage 235, voltage 25 and preheat 190° Celsius. The ZPMC Certified Welding Inspector (CWI) was Zhao Chen Sun. The back gouging was of weld 10 between the 75 millimeter plate's p1297 and SA234 on the 43 Meter Top Diaphragm. Heat straightening of plate's p830 and p414 was also observed. The ZPMC CWI observing the HS was Ye Yong Jun.

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Summary of Conversations:

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: Hager, Craig

QA Reviewer