

**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-002180**Date Inspected:** 16-Apr-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:** Shanghai, China

<b>CWI Name:</b>	Xu Le Feng & Zhu Zhonghai	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower Shop		

**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;

Tower Shop, SAW welder Yun Chuan Jin #0503060 was observed during the welding of the filler passes on weld 15A of Plate SSD1-SA173-A/K. The welding procedure being followed was WPS-B-T-2221-B-U3c-S. Welding parameters recorded by were, Amps 670, Volts 33.5 Travel Speed (T/S) 640 mm/min. and the Temperature was 180c. Also observed being welded was SSD1-SA16-E/G-11A by welder Chen Hengxia #040460. The welding wire was JN-3C/JF-B and was 4.8mm in diameter. Two other plates being welded were ESD1-SA107 A/J-18A by welder Xia Yongliu #048882 and plate ESD1-SA107 B/J-16A by welder Liu Juan #047481. The CWI/QC present for these welders was Zhu Zhonghai.

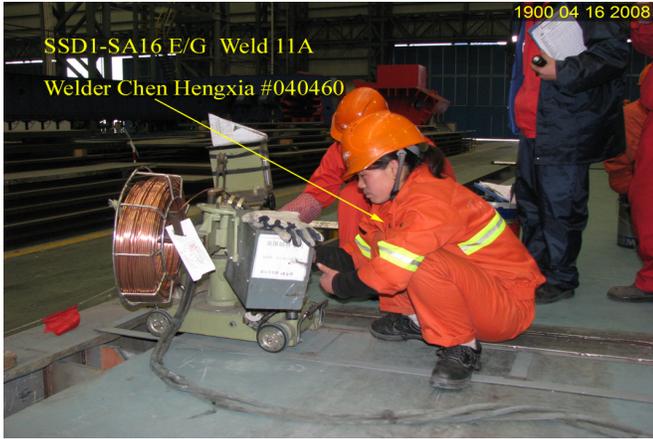
During the morning shift this Caltrans QA Inspector did photograph three lots of Macro Etched Samples. The three sample lots were Deck Panel DP-326, DP-409 and DP-324. The photographs for these Macro Etched Samples were placed in folders in the "Shared Docs on Team China Server" under Team OBG. The folder within this Team OBG is named "Macro Etched Samples" where the rest of the folders are kept according to the date they were photographed. Each of the Macro Etched Samples was photographed once in an over all view and if an indication existed then a close up photograph was taken to show this indication.

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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Smith, David

Quality Assurance Inspector

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**Reviewed By:** Hager, Craig

QA Reviewer