

**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-002186**Date Inspected:** 12-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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

**Summary of Items Observed:**

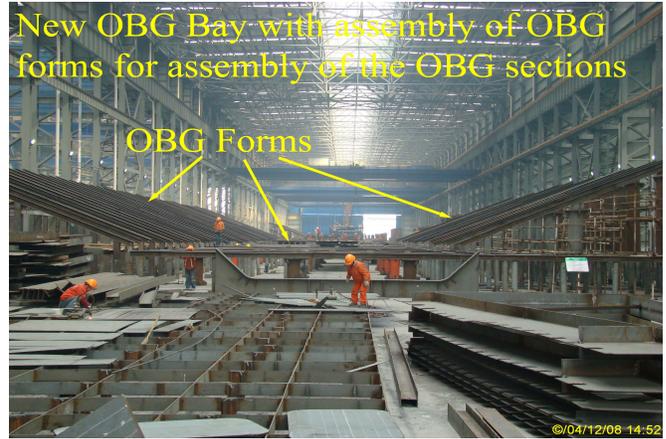
This Quality Assurance Inspector (QAI) witnessed welding in the New OBG Bay on the splicing of various side plate and bottom plate segments. Welding was being carried out on complete joint penetration (CJP) welds SEG020A-015; SEG020A-001 and SEG017A-003. Welder Hong Yong Li, welder identification 044801 was observed welding side plates SP067B to SP055B for weld joint SEG020A-015. Some of the essential variable observed and recorded were amperage 290, voltage 29.2 and preheat temperature 71° Celsius for this flux core arc weld (FCAW). Welder Sun Gu Zuo, welder identification 058100 was observed welding side plates SP024A to SP01A for weld joint SEG020A-001. Welder Wang Lan Ying, welder identification 045265 was observed welding bottom plates BP13A to BP14A for weld joint SEG017A-003 with the submerged arc welding (SAW) process and some of the essential welding variables observed and recorded were amperage 540, voltage 31, preheat temperature 40° Celsius and travel speed 460 millimeters per minute.

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# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Berger, Bruce

Quality Assurance Inspector

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**Reviewed By:** Hager, Craig

QA Reviewer