

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000786**Date Inspected:** 06-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi & Xu Le Feng**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:** Mock Up**Summary of Items Observed:**

Elevation 89M:

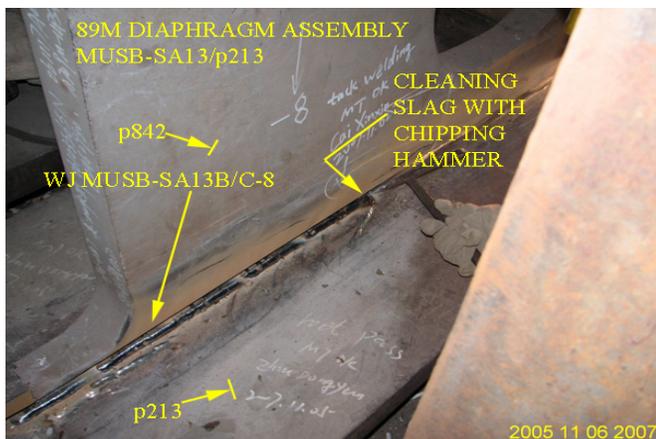
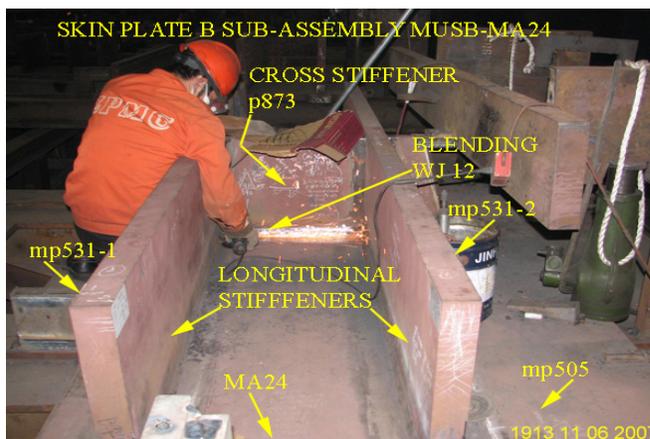
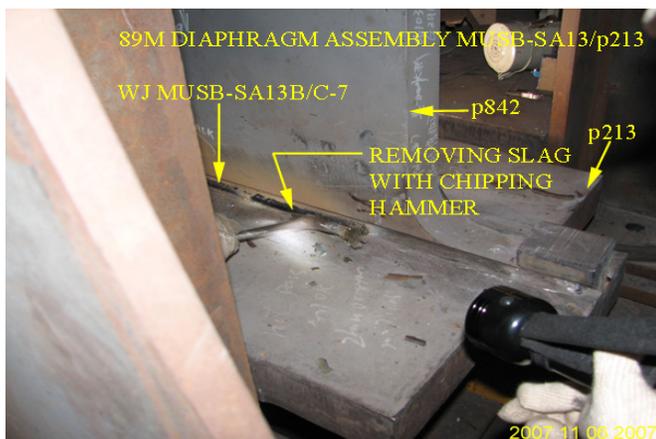
The QA Inspector was present at the time requested to randomly observe welding and associated operations for the fabrication of the Tower Mock Up.

The QA Inspector randomly observed a ZPMC helper utilizing a grinder to blend the face of Weld Joint (WJ) 12 on Skin Plate B Sub-Assembly MUSB-MA24. The following photograph provides additional detail.

The QA Inspector randomly observed ZPMC welders Jin Rong ID Number 066471, He Shebing ID Number 066243, Li Zhengxu ID Number 066179 and Jiang Xiaohu ID Number 066155, utilizing the SMAW process with approved ZPMC WPS WPS-B-T-3312-TC-P5 and Excaliber E9018 electrode, to weld the root passes in the 2G position on WJ MUSB-SA13B/C-7 and WJ MUSB-SA13B/C-8 respectively, on 89M Diaphragm Assembly MUSB-SA13/p213. WJ's MUSB-SA13B/C-7 and MUSB-SA13B/C-8 were on opposite sides of web plate piece mark p842, at the attachment to the Lower Diaphragm Assembly MUSB-p213. The QA Inspector observed ZPMC CWI's Sha Zhi and Xu Le Feng monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows: welding amperage 258 amps, welding voltage 24 volts with a travel speed of 145 millimeters per minute for Mr. Jiang, 253 amps, 24.1 volts with a travel speed of 162 millimeters per minute for Mr He, 253 amps, 24.1 volts with a travel speed of 155 millimeters per minute for Mr Jin and 242 amps, 23.9 volts with a travel speed of 142 millimeters per minute for Mr. Li. Weld parameters appeared to comply with the above approved ZPMC WPS. The following photographs provide additional detail.

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Summary of Conversations:

There were no relevant conversations.

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: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer