

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000043
Date Inspected: 04-Nov-2006

Project Name: SAS Superstructure **OSM Arrival Time:** 830
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1730
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

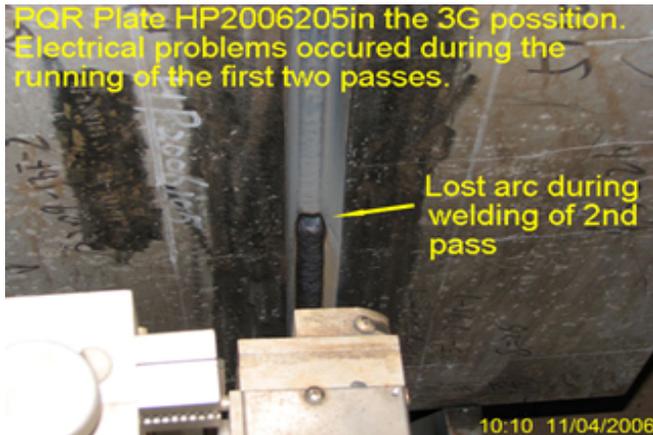
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|------------------------------------|------------|----------------------------------|-----|--------|
| CWI Name: | Liu Liu | CWI Present: | Yes | No |
| Inspected CWI report: | Yes No N/A | Rod Oven in Use: | Yes | No N/A |
| Electrode to specification: | 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: | N/A | |

Summary of Items Observed:

This Office of Structural Materials Quality Assurance Inspector observed welding and quality control functions during procedure qualification testing at the ZPMC facility in Shanghai, Republic of China today.

| Item | Description | WBS | Dwg No. | Status |
|------|-------------|-----|---------|--------|
| 1 | | | | |

This Quality Assurance Inspector observed the Quality Control Inspector, Mr. Liu Liu witnessing the running of the flux core arc welding procedure qualification test HP2006105 in the shop at ZPMC. The test was being run to Paragraph 5.12 at the maximum heat input in the vertical welding position (3G). The welders were Lei Li Chao and Zhang Xing Jin who were using Hyundai, Supercored 71, and 1.4 millimeter diameter wire. Problems occurred during the running of the root weld due to power fluctuation and then again during the second pass.



WELDING INSPECTION REPORT

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Summary of Conversations:

A discussion was held with Liu Liu concerning the power fluctuations. Mr. Liu stated that they were going to suspend welding of the flux core welding to look into the cause of the electrical power problems.

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 |
| Reviewed By: | Lowry, Patrick | QA Reviewer |
