

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-000046
Date Inspected: 07-Dec-2006

Project Name: SAS Superstructure **OSM Arrival Time:** 800
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1500
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Huang Wei	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	

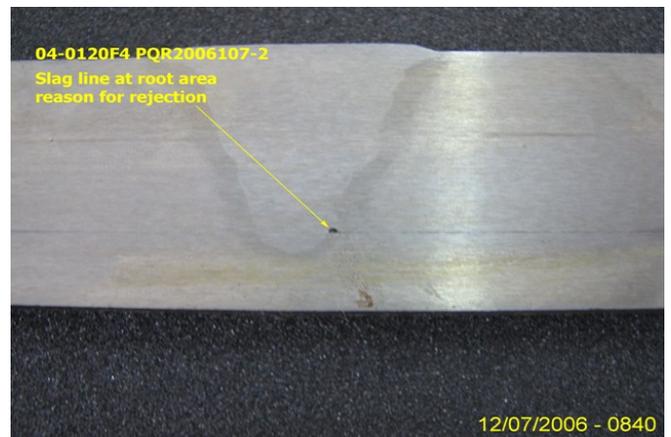
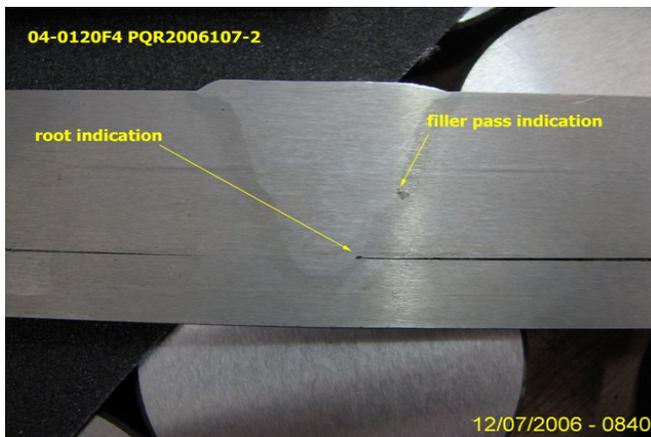
Summary of Items Observed:

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item	Description	WBS	Dwg No.	Status
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1

The QA Inspector did not observe welding on this date, but was asked to review radiographic film and macro etches for PQR 2006107-2. The macro etch reveal a slag line and an inclusion in the weld as shown below in photos.



2

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Items Observed: Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. The QA Inspector did not observe welding on this date, but was asked to review radiographic film and macro etches for PQR 2006107-2. The macro etch reveal a slag line and an inclusion in the weld as shown below in photos.

The second set of macro's for the trial run appeared to have good fusion in the root area. See the TL-6031 from Dave McClary on this date for macro photos. ZPMC QC Manager Lu Jian Hua stated that the weld was produced by trailing the electrode on this last trial test.

The ZPMC QC Manager Mr. Lu Jian Hua canceled the PQR testing on this date at 1500.

Summary of Conversations:

The QC Inspector with ZPMC Quality Control (QC) stated that they would be running more practice plates for the PQR 2006107. The QC stated that the macros show a slag line in the root area of the 3rd attempt at this PQR. The QC Inspector stated that they would be running PQR2006107-3 this afternoon at 1430.

The ZPMC QC Manager Mr. Lu Jian Hua stated at 1500 that the last boat trip would be canceled and that we had to leave without performing the PQR2006107-3 on this date.

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:	Wright,Mark	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
