

**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-000075**Date Inspected:** 01-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**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>	Liu Liu	<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>	N/A	

**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welding qualification testing pertinent for the welding qualification record (PQR) HP200706 scheduled for this project.

ZPMC, welder operator Jiang Xian Hu was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-2231-F-1 for the PQR identified as HP200706. Base metal was designated as A-709-50F-2 (Heat # 06103747020102) and met the fracture critical requirements. The root opening of the joint was approximately 10 mm. ZPMC followed the maximum heat input criteria (AWS 5.12.1) using the automatic flux cored arc welding gas (FCAW-G) process in the flat (1G) position with the 1.4 mm diameter TWE-711 electrode. The QA Inspector verified dimensions for the test coupon, amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspector was assisted by QA Mike Hasler. The QA inspectors recorded welding parameters for a total of 10 passes (6 layers). The QA inspectors discovered that the welding parameters taken by Quality Control (QC) inspector Cheng Libin and ZPMC QA inspectors Xu Jun and Hu Gang appeared to be accurate and in accordance with the contract documents. ZPMC QC Inspector Liu Liu witnessed the testing and performed visual weld inspections. The QA Inspector issued a lot number of B71-001-07 after the completion of the PQR. See TL\_6032 form for more details and the below digital photograph with the PQR test plate after completion.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QA inspector did not have any significant conversation 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.

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<b>Inspected By:</b>	Acuna,Alfredo	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary,David	QA Reviewer

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