

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000079**Date Inspected:** 02-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**CWI Name:** Bing Xi**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:** Bid: 52, 55 Tower & Girder**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Mr. Mike Hasler is present for the welding qualification testing pertinent for the welding qualification record (PQR) HP200707 scheduled for this project.

Caltrans QA Inspector, Mr. Hasler witnessed ZPMC, welder operator, Mr. Zhang Xing Jin perform submerged arc welding (SAW) per welding procedure specification (WPS). Caltrans QA observed ZPMC, QA Inspector Mr. Hu Gang and American Bridge/Fluor Inspector, Mr. Bing Xu monitoring and supervising the testing. The PQR is identified as HP200707, WPS PWPS-B-T-2221-FB-1 and 26 mm thick test plate meeting the fracture critical requirement and designated as A-709-50F-2 with Heat # 07200455030101. The root opening of the joint is approximately 16 mm. ZPMC followed the minimum heat input criteria (AWS 5.12.1) using the automatic SAW process in the flat (1G) position with the 4.8 mm diameter Hyundai H-14 electrode. ZPMC QA Inspector and ABF Inspector verified dimensions for the test coupon, amperages, voltages, travel speeds, preheat and heat interpass temperatures. Caltrans QA inspectors recorded welding parameters for a total of 8 passes (4 layers). Caltrans QA verified that the welding parameters taken by ZPMC QC and ABF QC inspectors appeared to be accurate and in accordance with the contract documents.

Summary of Conversations:

At 1600 hours ZPMC QA Inspector, Mr. Hu Gang terminated welding after the completion of the 8th weld pass. Mr. Gang stated that there is not enough time to complete the welding of the test plate during this work shift. Mr. Gang also stated that welding would be resumed on the test plate the following work day.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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: Hasler, Mike

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer