

**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-000081**Date Inspected:** 06-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:** 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:** Bid 52, 55 Tower & Girder**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Mr. Mike Hasler is present for the welding procedure qualification testing applicable for welding qualification record (PQR) HP200707 and HP200708 scheduled for this project.

At 0915 hours, ZPMC resumed the procedure qualification testing for HP200707 as mentioned above. With the original start date as reported in the Welding Inspection Report dated March 5, 2007. Caltrans QA Inspector, Mr. Hasler witnessed ZPMC, welder operator, Mr. Zhang Xing Jin perform submerged arc welding (SAW) per welding procedure specification (WPS) PWPS-B-T-2221-FB-1. Caltrans QA observed ZPMC, QA Inspector Mr. Hu Gang and American Bridge/Fluor Inspector, Mr. Bing Xu monitoring and supervising the testing for the minimum heat input criteria per AWS 5.12.2, amperages, voltages, travel speeds, preheat and heat interpass temperatures. Caltrans QA Inspector recorded welding parameters for the 24th and 25th final weld pass. Caltrans QA Inspector verified that the welding parameters taken by ZPMC QC and ABF QC inspectors appeared to be accurate and in accordance with the contract documents. Lot number issued was B49-002-07. See Caltrans Welding Witness Report, TL-6032, dated March 6, 2007 for additional information.

At 1000 hours, Caltrans QA Inspector witnessed ZPMC, welder operator, Mr. Zhang Xing Jin perform submerged arc welding (SAW) per procedure qualification HP200708 and welding procedure specification (WPS) PWPS-B-T-2221-FA-1 requirements. Caltrans QA observed ZPMC, QC Inspector Mr. Gu Fu Min and American Bridge/Fluor Inspector, Mr. Song Wei Min monitoring and supervising the testing for the maximum heat input criteria per AWS 5.12.2, amperages, voltages, travel speeds, preheat and heat interpass temperatures. Caltrans QA Inspector verified that the welding parameters taken by ZPMC QC and ABF QC inspectors appeared to be

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

accurate and in accordance with the contract documents. Lot number issued was B49-003-07. See Caltrans Welding Witness Report, TL-6032, dated March 6, 2007 for additional information.

## Summary of Conversations:

As identified within the contents of this report.



## 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