

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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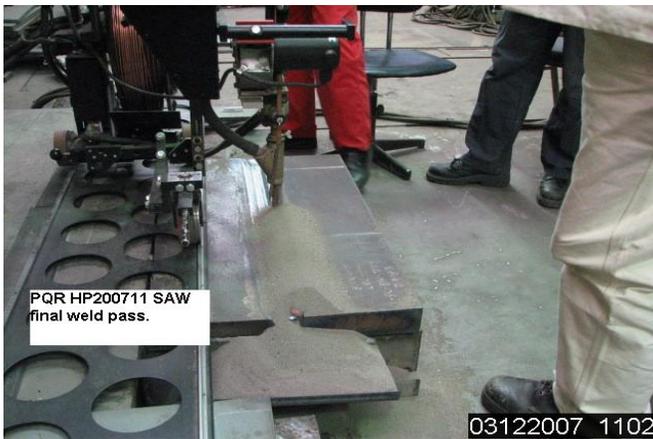
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000092**Date Inspected:** 12-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Bing Xu**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 procedure qualification record (PQR) HP200711 scheduled for this project.

At 0930 hours, ZPMC resumed the procedure qualification testing for HP200711 as mentioned above. With the original start date as reported in the Welding Inspection Report dated March 9, 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-223(2)1T. Caltrans QA observed ZPMC, QA Inspector Mr. Hu Gang and Quality Control Inspector, Mr. Bing Xu monitoring and supervising the testing criteria per AWS 5.13, amperages, voltages, travel speeds, preheat and heat interpass temperatures. Caltrans QA Inspector recorded welding parameters for the 50th through 60th final weld pass. Caltrans QA Inspector verified that the welding parameters taken by ZPMC QA and QC inspectors and supporting documentation appeared to be accurate and in accordance with the contract documents. Lot number issued was B49-006-07. See Caltrans Welding Witness Report, TL-6032, dated March 12, 2007 for additional information.

WELDING INSPECTION REPORT

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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
