

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-000096
Date Inspected: 17-Mar-2007

Project Name: SAS Superstructure **OSM Arrival Time:** 800
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1630
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:	Bid: 52, 55, Tower & Girder	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector was present to witness procedure qualification (PQR) HP200716 as requested by ZPMC. The test plate was welded in the 1F (flat) position, using the submerged arc welding (SAW) automatic welding process. The test consisted of a maximum single and minimum multi pass weld fillet weld. The welding consumable (electrode) is identified as specification AWS A5.17, classification AWS EH14 and 4.8 mm diameter electrode. The welding was performed in accordance with AWS D1.5, Section 5 para. 5.10.3 fillet weld soundness requirements. The welding appeared to comply with the contract documents. Caltrans QA Inspector assigned lot number B49-008-07 for the maximum size single pass and B49-009-07 for the minimum size multi pass weld. See Caltrans Welding Witness Report (TL-6032), dated March 17, 2007 for additional information.



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Summary of Conversations:

As identified with in 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
