

**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-000138**Date Inspected:** 01-May-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:** PQR Testing**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to welding, testing and fabrication procedures at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

At 0930 hours, Caltrans QA Inspector witnessed ZPMC, welder, Mr. Zhu Hai Ping perform shielded metal arc welding (SMAW) procedure qualification record (PQR) test. Caltrans QA observed ZPMC QA Manager, Mr. Liu Liu and Quality Control Inspector, Mr. Cheng Li Bin monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and interpass temperatures. The PQR is identified as HP200776, WPS PWPS-B-T-3211. The test plate type and thickness is identified as A709 Grade HPS485W, 75 mm. The PQR testing was performed in the 1G position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M-H4R. Caltrans QA inspector recorded welding parameters for weld pass 23 through 46. Caltrans QA verified that the welding parameters taken by ZPMC QC inspector appeared to be accurate and in accordance with the contract documents. Welding performed appeared to comply with project documents. At 1600 hours ZPMC QA Manager, Mr. Liu terminated welding after the completion of the 46th weld pass. Mr. Liu stated that welding of the test plate would be resumed tomorrow May 2, 2007.

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# 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.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

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**Reviewed By:** McClary, David

QA Reviewer