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-000142
Date Inspected: 05-May-2007

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 800
OSM Departure Time: 1730
Location: Shanghai, China

CWI Name:	Wei Huang			**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 Test

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 Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

At 1300 hours, Caltrans QA Inspector witnessed ZPMC perform shield metal arc welding (SMAW) procedure qualification record (PQR) test. The welder is identified as Mr. Zhu Hai Ping. The PQR is identified as HP200777, WPS PWPS-B-T-3213. The test plate material type is identified as A709 Grade HPS485W and thickness, 75 mm. The PQR testing was performed in the 3G position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M-H4R. Caltrans QA observed ZPMC QA Inspector, Mr. Cheng Li Bin and Mr. Wei Huang monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and interpass temperatures. QA observed that the ZPMC testing center for ambient temperature and wind velocity appear to be in conformance with AWS D1.5, paragraph 3.1 and 4.14.3 requirements.
Caltrans QA inspector recorded welding parameters for a total of 1 through 7 weld passes. Caltrans QA verified that the welding parameters taken by ZPMC QC inspector, appeared to be accurate and in accordance with the contract documents. At 1630 hours ZPMC QA Inspector, Mr. Cheng Li Bin terminated welding after the completion of the 7th weld pass. Mr. Cheng stated that welding would be resumed tomorrow, May 6, 2007.

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