

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-000143**Date Inspected:** 03-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 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 ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item	Description	WBS	Dwg No.	Status
1	PQR HP200776			Welding in progress
	<p>At 0930 to 1100 hours, Caltrans QA Inspector witnessed ZPMC, welder, Mr. Zhu Hai Ping perform shield 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 and 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 70 through 78. 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. Mr. Alfredo Acuna resumed the witnessing of PQR welding for the remainder of the work shift.</p>			

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



2 ABF Mockup Fitup and welding in prog

At 1500 hours, Caltrans QA Inspector observed twenty (20) ZPMC shop personnel performing fit up, welding and QC inspections on American Bridge/Fluor (ABF) mockups, designated as elevation 77.000 (diaphragm 3B), elevation 89.000 (diaphragm 1A & 1B), elevation 114.000 (tower splice) at ZPMC OBG workshop

Caltrans QA observed twenty (20) ZPMC shop personnel fitup and preparation welding of the ribs to deck plate at the other ZPMC OBG workshop.

Caltrans QA observed ZPMC and ABF/Inspectech inspectors performing observations and inspections.



Summary of Conversations:

See Task Leader journal for this week.

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