

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-000144**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:	N/A	

Summary of Items Observed:

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welding qualification testing pertinent for the welding qualification record (PQR) HP200776 scheduled for this project. ZPMC, welder Zhuhai Ping was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-3211 for the PQR identified as HP200776. Base metal was designated as A-709M-HPS-485W/Z25 (Heat # 06103445N) and appeared to meet the fracture critical requirements. The root opening of the joint was approximately 6 mm. ZPMC followed AWS 5.13 Production procedure WPS using shielded metal arc welding (SMAW) process in the flat (1G) position with the 4.0 mm diameter Excalibur E9018M-H4R electrode. The QA Inspector randomly verified amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspector recorded welding parameters for a total of 16 passes. The QA inspector observed that the welding parameters taken by ZPMC QA inspectors Cheng Li Bin and Liu Liu appeared to be accurate and in accordance with the contract documents.

Note: The QA inspector was assisted by the Caltrans QA inspector Mike Hasler on this date. See Mr. Hasler TL_6031 for this date.

Summary of Conversations:

The QA inspector did not have any significant conversations on this date.

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.

WELDING INSPECTION REPORT

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Inspected By:	Acuna, Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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