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-000147
Date Inspected: 07-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 Hang

Inspected CWI report:	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☑ No	☐ N/A

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☑ 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 0930 hours, ZPMC resumed PQR HP200777 weld test. Caltrans QA Inspector witnessed ZPMC welder, Mr. Zhu Hai Ping perform shield metal arc welding (SMAW) 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. Wei Huang and Ms. Meng Chun Xia 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 10 weld passes, 17 through 26. Caltrans QA verified that the welding parameters taken by ZPMC QC inspector, appeared to be accurate and in accordance with the contract documents. At 1600 hours ZPMC QA Inspector, Mr. Wei Huang terminated welding after the completion of the 26th weld pass. Mr. Cheng stated that welding would be resumed tomorrow, May 8, 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