

**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-000149**Date Inspected:** 04-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

<b>CWI Name:</b>	Liu Liu			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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 17 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.

The QA inspector performed final visual examination to the test coupon after completion of the PQR HP200776. The QA inspector observed that the welds appeared to be in general compliance with the contract documents. The QA inspector assigned a lot # B71-022-07 on this date. The digital photograph below shows the PQR test coupon.

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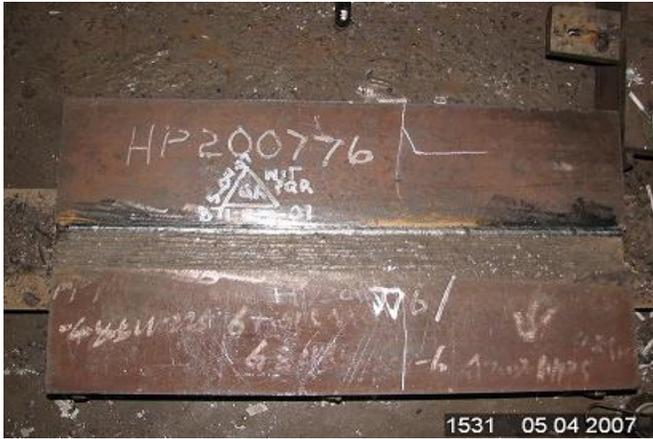
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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## 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.

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<b>Inspected By:</b>	Acuna,Alfredo	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClary,David	QA Reviewer
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