

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000152**Date Inspected:** 07-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:** Huang Wei**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 mechanical testing on the welding qualification tests for the procedure qualification record (PQR) PQR 200778 scheduled for this project.

The testing was at the ZPMC facility in Shanghai, China. The QA Inspector observed tensile test on reduced sections and all weld metal specimens along with side bends, Charpy Vee Notch (CVN) and macro etch tests. The test was performed per the AWS D1.5, Section 5.18 requirements and special provisions. The tests appeared to be in general compliance with the contract documents. The QA Inspector issued a lot number of B71-023-07. See TL_6032 for details of this test.

The digital photograph below shows test coupons for the PQR 200778.



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Summary of Conversations:

The QA inspector had a conversation with ZPMC QA representative Hu Gang. The QA inspector brought to Mr. Gang attention that ZPMC was using the CVN temperature of -30 °C in lieu of -18 °C in accordance with the special provisions for testing 5 coupons (HPS 485W) at the heat affected zone (HAZ). After, Mr. Gang confirmed with ZPMC technical department. Mr. Gang agreed that the CVN testing temperature needed to be changed to -18° C to determine the toughness of the HAZ from the 5 test coupons. ZPMC performed CVN testing with -18 °C.

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