

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-000180**Date Inspected:** 22-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 welding qualification testing pertinent for the welding qualification record (PQR) HP200776-1 scheduled for this project. ZPMC, welder Zhu hai 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 HP200776-1. Base metal was designated as A-709M-HPS-485W/Z25. ZPMC followed AWS 5.13 Production procedure WPS using shielded metal arc welding (SMAW) process in the flat (1G) position with the 4.8 mm diameter Excalibur E9018M-H4R electrode. The QA Inspector verified amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspectors recorded welding parameters for a total of 11 passes. The QA inspector observed that the welding parameters taken by ZPMC QC inspectors Huang Wei and ABF representative Song Wemin appeared to be accurate and in accordance with the contract documents.

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.

Inspected By: Acuna, Alfredo

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Reviewed By: McClary, David

QA Reviewer