

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-000186**Date Inspected:** 28-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:** Wei Huang**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:** HP200778-1, 79-1 & 81-1**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Bruce Berger 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.

Caltrans QA Inspector witnessed ZPMC continuing to perform shield metal arc welding (SMAW) procedure qualification record (PQR) HP200778-1, PWPS-B-T-3214 test. The welder is identified as Mr. Zhu Hai Ping, welding passes eleven through the final pass, thirteen. The test plate material type is identified as A709 Grade HPS485W and thickness, 25 mm. The PQR testing was performed in the 4G position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M H4R, specification AWS A5.5. Caltrans QA observed ZPMC QA Inspector, Mr. Wei Huang and two associates monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and inter-pass temperatures. Also present at the test site was American Bridge/Fluor (ABF) subcontractor, Inspectech, quality control (QC) inspector, Mr. Song Wei Min. QA observed that the wind velocity at the ZPMC testing site appear to be in conformance with AWS D1.5, paragraph 4.14.3 requirements. Welding was completed prior to lunch time. For details see Welding Witness Report TL-6032 date May 28, 2007.

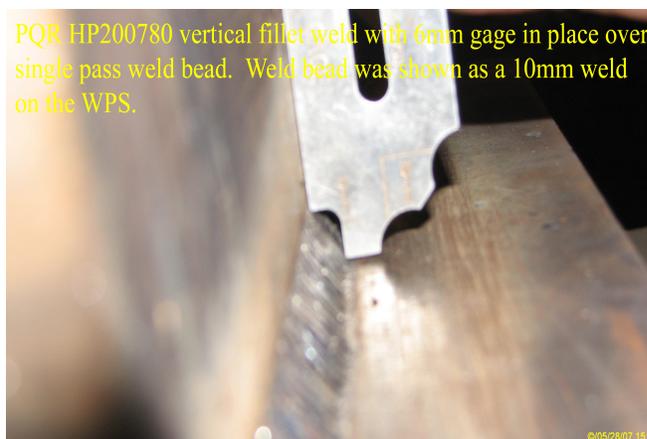
Caltrans QA Inspector witnessed ZPMC perform shield metal arc welding (SMAW) procedure qualification record (PQR) HP200781-1, PWPS-B-T-3114 test. The welder is identified as Mr. Zhu Hai Ping, welding passes one through three. The test plate material type is identified as A709 Grade HPS485W and thickness, 25 mm. The PQR fillet weld testing was performed in the 4F position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M, specification AWS A5.5. Caltrans QA observed ZPMC QA Inspector, Mr. Wei Huang and

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two associates monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and inter-pass temperatures. Also present at the test site was American Bridge/Fluor (ABF) subcontractor, Inspectech, quality control (QC) inspector, Mr. Song Wei Min. QA observed that the wind velocity at the ZPMC testing site appear to be in conformance with AWS D1.5, paragraph 4.14.3 requirements. ZPMC completed PQR testing for HP200781-1. For details see Welding Witness Report TL-6032 dated May 28, 2007.

Caltrans QA Inspector witnessed ZPMC perform shield metal arc welding (SMAW) procedure qualification record (PQR) HP200779-1, PWPS-B-T-3112 test. The welder is identified as Mr. Zhu Hai Ping, welding passes one through three. The test plate material type is identified as A709 Grade HPS485W and thickness, 25 mm. The PQR fillet weld testing was performed in the 2F position. The welding consumable is identified as a 4.8 mm electrode, classification E9018M H4R, specification AWS A5.5. Caltrans QA observed ZPMC QA Inspector, Mr. Wei Huang and two associates monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and inter-pass temperatures. Also present at the test site was American Bridge/Fluor (ABF) subcontractor, Inspectech, quality control (QC) inspector, Mr. Song Wei Min. QA observed that the wind velocity at the ZPMC testing site appear to be in conformance with AWS D1.5, paragraph 4.14.3 requirements. ZPMC completed PQR testing for HP200779-1. For details see Welding Witness Report TL-6032 dated May 28, 2007.



Summary of Conversations:

No relevant conversations took place 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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
