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-000214
Date Inspected: 02-Jun-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 Huang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ 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: HP200777-1

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 Quality Assurance (QA) Inspector Bruce J. Berger continued witnessing ZPMC performing shield metal arc welding (SMAW) procedure qualification record (PQR) HP200777-1, PWPS-B-T-3213 test. The welder is identified as Mr. Zhu Hai Ping, welding passes twenty-six through thirty-nine. The test plate material type is identified as A709 Grade HPS485W and thickness, 75 mm. The PQR complete joint penetration groove weld testing was performed in the vertical up (3G) position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M MR, 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)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 not completed prior to the completion of the shift, so welding will continue tomorrow morning.

WELDING INSPECTION REPORT

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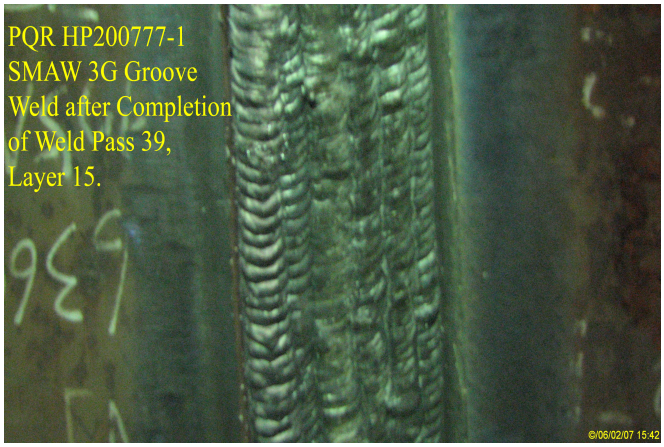

Summary of Conversations:

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