

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-000255**Date Inspected:** 29-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Bing**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:****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) HP2007147-1 scheduled for this project. ZPMC, welder operator Zhang Xin Jin was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-3221 for the PQR identified as HP2007147-1. Base metal was designated as A-709 Grade HPS485WT2/Z (Heat # 07101250N). ZPMC followed the Production procedure WPS criteria (AWS 5.13) using the submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter LA-85 flux brand MIL800-HPNi. The QA Inspector verified dimensions for the test coupon, amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspector witnessed ZPMC welding passes 60 through 64 (layers 23 and 24). The QA inspector recorded welding parameters for a total of 5 passes. The QA inspectors found that the welding parameters taken by Quality Control (QC) inspector Xu Bing and ZPMC QA inspector Zhu Zhong Hai appeared to be accurate and in accordance with the contract documents. ZPMC QC Inspector Xu Bing witnessed the testing and performed visual weld inspections. The PQR was still in process at the end of the shift. ABF representative Kevin Dye was present at the PQR tests. At 1405 hours Mr. Dye stopped ZPMC for continuing welding the PQR HP2007147-1 because ABF representative had to leave the testing area.

The photo below shows the test plate for the PQR HP2007147-1 at the end of the shift.

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Summary of Conversations:

The QA did not have any relevant conversation at the end of the shift.

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
