

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-000281**Date Inspected:** 06-Jul-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:** 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:** 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) HP2007370 scheduled for this project. ZPMC, welder operator Xiang Jie was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-2241-U-3 for the PQR identified as PQR HP2007370. Base metal was designated as A-709 50T-2/Z (Heat #07102643010102). ZPMC followed the Production procedure WPS criteria (AWS 5.13) using the gas metal arc welding (GMAW) process in the flat (1G) position with the 1.4 mm diameter designated as ER70S-6/AWS A5.18, brand name JM-56. The QA Inspector verified dimensions for the test coupon, amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspector witnessed 20 passes from layers 1 thru 9. The QA inspectors performed random verifications of the welding parameters for a total of 20 passes. The QA inspectors found that the welding parameters reported by Quality Control (QC) inspector Xu Bing and certified welder inspector Xiong WenHui appeared to be accurate and in accordance with the contract documents.

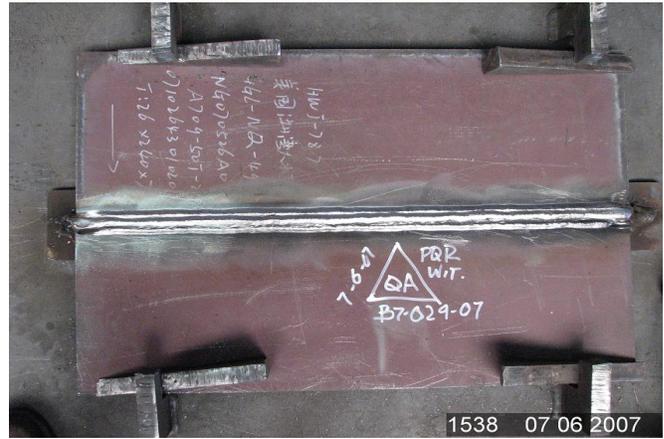
The QA inspector performed final visual inspection to the PQR HP2007370 test coupon after completion and observed that the weld reinforcement appeared to be in compliance with the contract documents. The QA inspector assigned Caltrans lot # B71-029-07 to this PQR coupon.

Note: PQR HP2007370 testing was performed at the site with the Gantry Lincoln welding machine (Power wave 455M), ABF personnel, Kevin Dye, Dustin Brungardt and Steve Lawton were presented during the PQR testing.

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The photos below show ZPM personnel and ABF personnel presented during the PQR testing and the PQR test coupon after completion.



Summary of Conversations:

The QA inspector did not have any relevant conversation 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.

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