

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



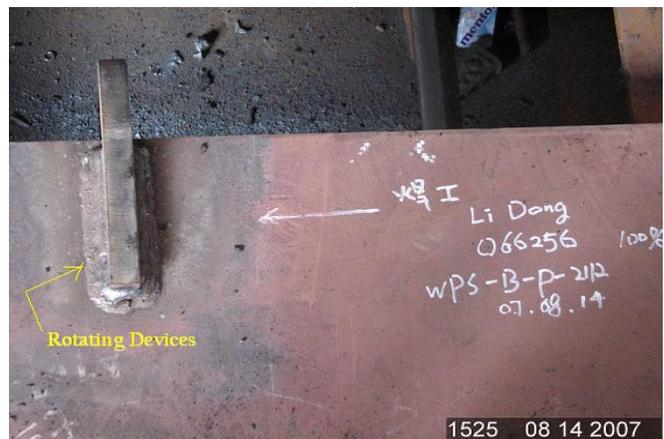
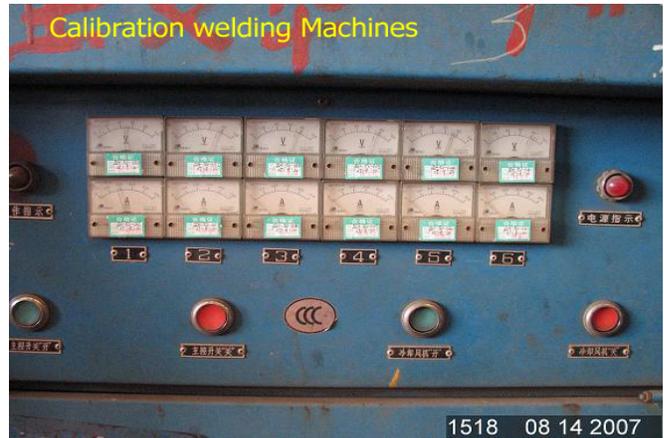
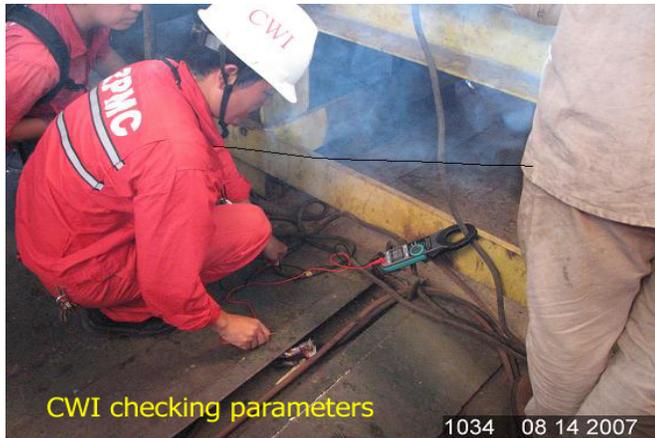
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000369**Date Inspected:** 14-Aug-2007**Project 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 Lefeng**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 fabrication of the Mock-up 77 meters elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. ZPMC removed the hold down devices welded to fit-up table frame at the skin plate panel E. ZPMC approved welders Li Dong and Chen Ruyang were observed by the QA Inspector performing welding operations following the approved welding procedure specification WPS-B-P-2112. Base metal was designated as A-709 Grade 50. ZPMC was using the Shielded Metal arc welding (SMAW) process in the horizontal (2F) position with the 4.0 mm diameter electrode designated as E7018/AWS A5.1, brand name TL-508. The QA Inspector verified joint fit-up, amperages, preheat and heat interpass temperatures. The QA inspector found that the welding parameters reported by Xu Lefeng approved ZPMC Certified Welding Inspector (CWI) and Certified Associate Welding Inspector Zhu Zhonghai appeared to be in accordance with the contract documents. The QA inspector had a conversation with ABF Production Manager Mr. Dave Williams. The QA inspector asked Mr. Dave Williams what was ZPMC welding schedule on this date. Mr. Dave Williams relayed to the QA inspector that ABF would stop ZPMC from welding at the 1600 hours due to ZPMC and ABF were still discussing transportation and schedules for covering off shift work. The digital photographs below show ZPMC at the start of the welding on the mock-up for diaphragm 77 and some of the QA's verifications performed at the start of the trial.

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Summary of Conversations:

As noted above.

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
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Reviewed By:	Cuellar, Robert	QA Reviewer
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