

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: 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-000376**Date Inspected:** 23-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Huang Wei**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:** PQR**Summary of Items Observed:**

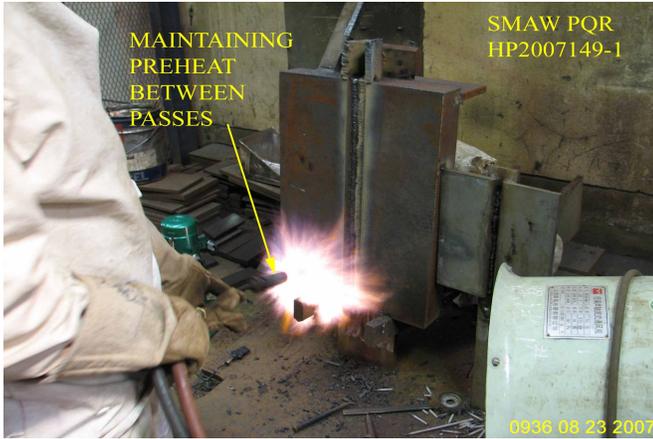
Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding being performed for Procedure Qualification Record (PQR) Number HP2007149-1. The welding is being performed with the shielded metal arc welding (SMAW) process in the 3G or vertical groove position. The PQR weld joint is a single V groove with a 30 degree included groove angle, a 10 millimeter root opening with a 20 millimeter thick by 200 millimeter wide steel backing strip. The QA Inspector observed ZPMC CWI Huang Wei monitoring preheat, welding amperage and welding voltage. Mr. Wei was being assisted in the morning by ZPMC CWI YeYong Jun of the ZPMC Technological Department, who was monitoring travel speed and recording all weld parameters. Mr. Wei did not return after lunch and Mr. Jun took over the responsibilities of monitoring welding amperage and welding voltage. Mr. Jun was assisted by He Zhi Ming of the ZPMC Technological Department, who was monitoring travel speed and recording all weld parameters. The QA Inspector also performed random verification of the above weld parameters and documented same. The welding started today with weld pass (WP) 51-19 and temporarily discontinued at WP 64-21 at the end of the shift. The following photograph provides additional detail.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Mr. Jun informed the QA Inspector that there were only one or two passes remaining to complete the welding for this PQR.

## 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:** Franco,Charlie

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer