

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



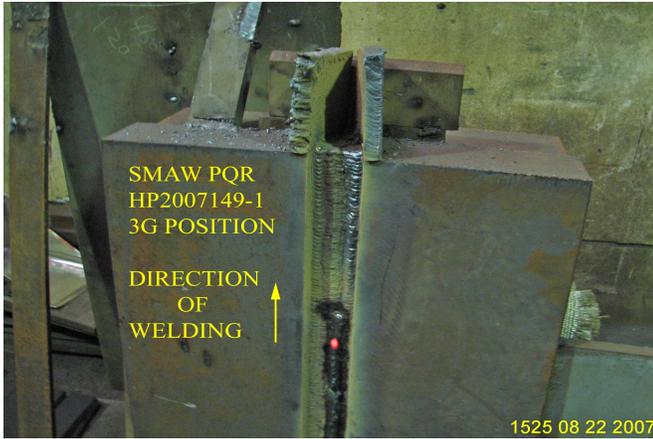
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000377**Date Inspected:** 22-Aug-2007**Project 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:** 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 by ZPMC CWI Ye Yong Jun 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) 38-16 and finished with WP 50-19. The following photograph provides additional detail.

WELDING INSPECTION REPORT

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Summary of Conversations:

Mr. Wei informed the QA Inspector that the PQR would resume at approximately 0900 tomorrow morning.

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:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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