

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-000405**Date Inspected:** 05-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Jian Ping & Huang Li**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:** Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77.00 and 114.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate E	NA	NA	Work In Progress

Mock-Up 77.00, skin plate E assembly: Caltrans QA Inspector observed ZPMC shop worker perform air carbon arc backgouge, weld joint preparation. The stiffener plate is identified as mp5-1 to MA1, weld map number MUSA-MA1-3A. ZPMC QA inspector, Mr. Shen Xue Jun reported that the grinding of the weld joint would not be completed during this workshift, but would be turned over to day shift for completion. Following digital picture illustrated weld joint preparation.

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2 Skin Plate C (top) NA NA Work In Progress

Mock-Up 114.00, Skin Plate C (top plate): Caltrans QA Inspector observed submerged arc welding (SAW) in progress at plate piecemark, mp1019 to MA112, weld number MUSC-MA-112-1, MUSC-MA112-2 and mp1021 to MA112, and weld number MUSC-MA-112-4. The approved welder operator is observed welding a partial joint penetration (PJP) fill/cover pass weld in the flat position. Welder is identified as Mr. Han Chang Hou. The welder is using welding procedure specification WPS-B-T-2321-B-P3-S, Revision 0. Caltrans QA measured current welding parameters at approximately 650 amps, 34.5 volts and travel speed, 630 millimeters per minute (mm/min). Preheat and interpass temperatures were verified during welding activities. Preheat temperature prior to the start of welding measures more than 110 degrees Celsius (230 degree Fahrenheit) but less than 232 degrees Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. SAW consumables were verified and identified as JW-3, classification EM12K, diameter 4.8 mm (.189 inches) electrode and, JF-B Flux, classification F7A2. Following digital picture illustrates welding in progress at weld number MUSC-MA112-1.



Summary of Conversations:

As identified within the contents of this report.

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:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
