

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-000417**Date Inspected:** 28-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

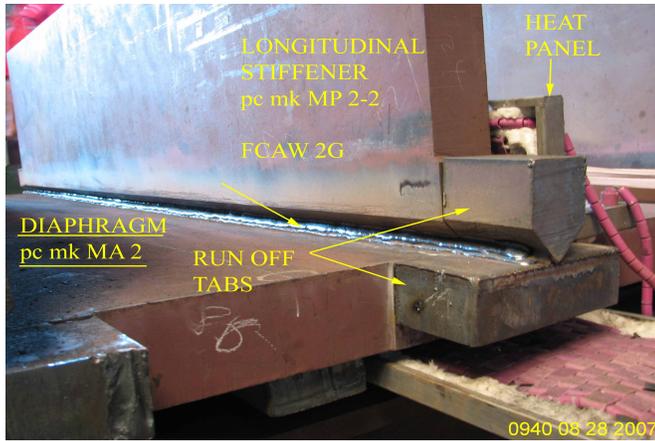
CWI Name:	Fu Hufong	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	MOCK UP	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding being performed for the fabrication of the Mock Up at elevation 77. The QA Inspector observed ZPMC welder Liu Xie, utilizing the flux cored arc welding process to weld side A of longitudinal stiffener piece mark MP2-2 on to diaphragm piece mark MA2. Mr. Xie was utilizing ZPMC weld procedure specification WPS-B-T-2232-TC-U5-F in the 2G or horizontal groove position. Other work observed included the attachment of new rotating devices to skin panel MP 14 after the machining of the bevels. This work was being performed by ZPMC welder Li Dong utilizing the shielded metal arc welding process in the 2F or horizontal fillet position with ZPMC weld procedure specification WPS-B-P-2112. The QA Inspector observed ZPMC CWI Fu Yuhong monitoring preheat, welding amperage and welding voltage. The QA Inspector also performed random verification of the above weld parameters and documented same. The welding amperage was 295 amps with a corresponding welding voltage of 31 volts and a travel speed of 355 millimeters per minute. The work monitored for weld parameters was the attachment of the longitudinal stiffener. Weld parameters appeared to be in compliance. Welding was discontinued on side A and heat panels were placed over the weld while the root of the weld was back gouged from the opposite side with the carbon air arc gouging process. The following photograph provides additional detail.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

There were no relevant conversations.

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
----------------------	----------------	-----------------------------

Reviewed By:	Cuellar,Robert	QA Reviewer
---------------------	----------------	-------------