

**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-000426**Date Inspected:** 24-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

<b>CWI Name:</b>	Xa La Feng	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 Mock Up at elevation 77. The welding is being performed with the submerged arc welding (SAW) process in the 1G or flat groove position. ZPMC welder Xue Yi An was observed welding the splice between skin plates Mp-12 and Ma-4, and ZPMC welder Shen Mei was observed welding the splice between Mp-13 and Ma-4. The QA Inspector observed ZPMC CWI Xa La Feng monitoring preheat, welding amperage, welding voltage and travel speed. The QA Inspector also performed random verification of the above weld parameters at a weld amperage of 685 amps with a corresponding weld voltage of 32 volts and a travel speed of 611.2 millimeters per minute on the cover pass of weld splice Mp-13 to Ma-4. The weld procedure in use was WPS-B-T-2321-B-P3-S. The QA Inspector also observed ZPMC NDT Technician Cai Xin Xin performing magnetic particle examination of the cover pass on the weld splice between skin plates Mp-16 and Ma-5. There appeared to be no indications. The following photograph provides additional detail.

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# WELDING INSPECTION REPORT

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## 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.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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