

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-000429**Date Inspected:** 24-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 545**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:** Xu Lefeng**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:** N/A**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 meters elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. ZPMC, welder operator Shen Mei and Xue Yi An were observed by the QA Inspector performing welding operations on the skin panel C.

Mr. Xue was observed welding the filler and cover passes at the junction of the MA-4 to mp12 skin panel C following the approved welding procedure specification WPS-B-T-2321-B-P3-S. Base metal was designated as A-709 Grade 50. ZPMC was using the submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter electrode designated as EM12K/AWS A5.17, brand name JW-3. The QA Inspector verified amperage, voltage, travel speed, preheat and heat interpass temperatures. The QA inspector found that the welding parameters recorded after ZPMC approved Certified Welder Inspector Xu Lefeng appeared to be in accordance with the contract documents. ABF QA inspector Kevin Dye was present on the Tower Mock-up area. Ms. Shen was observed welding the filler and cover passes at the junction of the MA-4 to mp13 skin panel C following the approved welding procedure specification WPS-B-T-2321-B-P3-S. Base metal was designated as A-709 Grade 50. ZPMC was using the submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter electrodes designated as EM12K/AWS A5.17, brand name JW-3. The QA Inspector verified amperage, preheat and heat interpass temperatures. The QA inspector found that the welding parameters reported by Xu Lefeng approved ZPMC Certified Welder Inspector appeared to be in accordance with the contract documents. On this date, ZPMC was observed machining the bevels on the 77 tower elevation diaphragm plate piece marked as SA-104-1.

The QA inspector witnessed ZPMC magnetic particle testing (MT) examinations on the cover pass at the junction of the plate # MA-5 to mp14 skin panel D weld joint # 1 and the tack welds from the MA-1 to mp15 skin panel #

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E. The approved NDT MT technician Cai Xin Xin completed the test and he did not find any relevant indications.

Summary of Conversations:

As noted above.

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:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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