

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 #: 6928**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000443**Date Inspected:** 13-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Xu Bing**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:** 114 A,C and 77 A**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of the Caltrans Mock-up #114.00 and #77.00, for the San Francisco Oakland Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing Flux Core Arc welding (FCAW) at #77.00 Skin Plate C Stiffener welds. ZPMC QA Inspector Fu Yuhong stated, FCAW is being performed in accordance to WPS-345-FCAW-1G(1F) repair-1 and the welder performing the welding Mr. Li Ming Yang. The following digital picture illustrates FCAW in progress. Caltrans QA Inspector observed Stiffener fit up of Mock up 144.00 Skin C stiffeners MP1001 and MP1002 in progress.

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Mr. Xu Bing performing Visual testing (VT). The (VT) testing was performed on Mock-up #77.00 Skin A stiffener #MP2, weld #2 repair weld. Caltrans QA observed ZPMC monitoring welding parameters on the cover pass Skin Plate C stiffener welds. Caltrans QA inspector observed Air Carbon Arc Gouging in progress on Mock up #114.00 Skin C upper Section. The welding and Air Carbon Arc gouging appeared to be in conformance with AWS D1.5 2002 requirements.

The Caltrans QA Inspector performed (VT) examinations of the above mentioned appear to be in conformance with AWS D1.5 2002 requirements.

WELDING INSPECTION REPORT

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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.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
