

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-000445**Date Inspected:** 08-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:** Ye Yong Jun**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 Skin B and E**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of the Caltrans Mock-up #114.00, 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 Submerged Arc Welding (SAW) at Skin Plate E Lower section MA108-1 to MP1022. ZPMC QA Inspector Xu Jun stated, SAW is being performed in accordance to WPS-B-T-2321-B-P3-S and the welders performing the welding are Mr. Xiang Jie (day shift) and Mr. Hanchang Hou (night shift). The QA Inspector also observed ZPMC shop personnel performing Shielded Metal Arc Welding (SMAW) tack welding at skin plate B, piece mark MA 102-1, longitudinal stiffener plates to the skin plate. Mr. Fu Yuhong stated, tack welding is being performed with welding procedure WPS-B-P-2212-TC-U5b and welders performing the welding are Mr. Lin Guoxuam and Mr. Guo Dengyun. At the conclusion of fit up and tack welding, ZPMC QC Inspector Ye Yong Jun reported that the welds and attachment locations were found acceptable.

Caltrans QA Inspector observed ZPMC QC Inspector, Mr. Ye Yong Jun performed Visual testing (VT) of the #114.00 Skin E MP1022 to MA108-1 Filler passes weld #5 and (VT) of #114.00 Mock-up stiffener fit up and tack welding of stiffeners MP1006 and MP1009 to Skin Plate B MA101. The testing appeared to be in conformance with AWS D1.5 2002 requirements. At the conclusion of inspection, ZPMC QC Inspector Cui Yiru reported that the root pass of Skin Plate E and fit up of tack welds of skin plate B stiffeners were found acceptable.

The Caltrans QA Inspector performed (VT) and examinations of the above mentioned root pass and tack welds

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

appear to be in conformance with AWS D1.5 2002 requirements.

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
