

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-000447**Date Inspected:** 06-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:** Skin C & Skin B**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 C Lower section piece mark # MA111-1 to MP1017 weld #2. ZPMC QA Inspector Fu Yuhong stated, SAW is being performed in accordance to WPS-B-T-2321-B-P3-S and the welder performing the welding Mr. Lujan Ping.

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Mr. Zhou Dong Yun perform Magnetic particle testing (MT) and Visual testing (VT). The (MT) and (VT) testing was performed Mock-up #114.00 Skin Plate E lower section piece mark MA 108-1 to MP 1022 tack welds. Mr. Zhou Dong Yun performed (MT) and (VT) of Mock-up #114.00 Skin Plate C Lower Section MP 1017-1 to MA 111-1 weld #1 root pass, and Mock-up #114.00 Skin Plate B piece mark MP 1014-1 to MA 101-1 weld #1 cover pass. The testing appeared to be in conformance with AWS D1.5 2002 requirements. At the conclusion of inspection, ZPMC QC Inspector Xu Bing reported that the above mentioned weldments were found acceptable.

The Caltrans QA Inspector performed (VT) and (MT) examinations of the above mentioned root pass and tack welds appear to be in conformance with AWS D1.5 2002 requirements. See MT report TL 6028, generated on this date for further information.

Summary of Conversations:

As identified within the contents of this report.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
