

**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-000473**Date Inspected:** 04-Sep-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>	Cui Yi Ru	<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>	114 M Mock-Up	

**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector Alfredo Acuna was present for the fabrication of the Mock-up for the 114 meters elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

On this date, the QA inspector assisted QA Inspector Ms Sherri Brannon with observations relative to the orthotropic box girder fabrication and also the on-going mock up fabrication.

The QA inspector observed ZPMC, welders Li Dong and Zhang Quanfa performing welding operations on the skin E upper panel MA109 and skin D upper panel mp1020, tower splice 114 meters elevation following the approved welding procedure specification WPS-B-P-2112. Base metal was designated as A-709 Grade 345. ZPMC was using the Shielded Metal arc welding (SMAW) process in the horizontal (2F) position with the 4.0 mm diameter designated as E7018/AWS A5.1, brand name TL-508. The QA Inspector verified joint fit-up, amperages, preheat and heat interpass temperatures. The QA inspector found that the welding parameters reported by Cui Yi Ru approved ZPMC Certified Welder Inspector appeared to be in accordance with the contract documents.

**Summary of Conversations:**

The QA inspector did not have any relevant conversation on this date.

**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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# WELDING INSPECTION REPORT

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