

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000547**Date Inspected:** 27-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:** Shanghai, China**CWI Name:** Li Wen Sheng**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**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 114 Skin-D (MA110) Stiffener plate MP1011 A Magnetic Particle (MT) tests performed by Zhenhua Port Machinery Company (ZPMC) Level II MT technician Zhou Dong Yun on the ground down root pass for welds #10 and 11 which was monitored and MT/OK. Caltrans QA Inspector performed an MT test on the root passes #10 and 11 and found them to be in compliance with project specifications.

Item-2 77 Skin-A Repair weld of Stiffener MA2-3 by Yang Lei #040690 qualified with Shielded Metal Arc Welding (SMAW) in the 3G position. Welding parameters recorded by this QA Inspector were, Amps was 225, Volts 27 travel speed of 190 mm/min. The QA Inspector observed a Magnetic Particle (MT) test on the stiffener MP5 by Zhou Dong Yun MT/OK. Gouged out area was 998.5mm long. Caltrans QA Inspector performed an MT test on areas of the gouge and found it to be in compliance with the project specifications.

Item-3 114 Skin-A Stiffener plate P268. Tack welding in progress By welder (A) Geo Dengyun #0379977 and (B) Li Dong #070301091. Both welders are qualified for SMAW in the 3G position. Welding parameters recorded by this QA Inspector were, welder (A) 171, temperature 148c and welder (B) Amps 172 and the temperature was 159. Both welders were using TL508 welding rods with a welding procedure of WPS-B-P-2212-7C-U5b. The ZPMC QC was Wang Xiangpin.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

WELDING INSPECTION REPORT

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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:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
