

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-000571**Date Inspected:** 02-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Bing & Xu Lefeng**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:** 77 & 114 Meter Mock-Ups**Summary of Items Observed:**

This Quality Assurance Inspector observed ZPMC ultrasonic technicians Li Liming and E Shinquin performing ultrasonic testing on the 77 Meter Mock-Up, MUSA-MA-2, Face A Plate Sub-Assembly complete joint penetration Tee Welds number 2, 3, and 4. These were on repairs completed earlier today. Areas ultrasonically tested included for weld joint number 2 from 0 to 45 mm and 108 to 141 mm. For weld number 3 the area ultrasonically tested was 2000 mm long which was 100% of the weld length. On weld number 4 the area ultrasonically tested was about 0 to 60 mm in length. Weld joint number 4 was found acceptable by Li Liming & E Shinquin. Weld joints numbers 2 and 3 were found unacceptable. Weld joint 2 was found unacceptable by Li Liming and weld joint 3 by Li Liming and E Shinquin. There were two indication found in weld joint 2 by Li Liming which were a combined 90 mm in length and for weld joint number 3 there were 6 indications, 5 by Li Liming and 1 by E Shinquin, for a total of 280 mm in length found.

This Quality Assurance Inspector observed ZPMC qualified welder Jiang Zhou, welder identification 040261 and Chang Chuancang, welder identification 053870 welding complete joint penetration tee-welds on MUC-A58. The welding procedure being followed was WPS-B-T-2232-TC-U5 and the amperage was checked and found to be 320, the voltage 31.2/31.5, travel speed 296/314 mm per minute and an inter-pass temperature of 126/125 degrees C.

Summary of Conversations:

No significant conversations held today.

WELDING INSPECTION REPORT

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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:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
