

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-000584**Date Inspected:** 03-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Lefeng & Hou Jing Tao	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:	Caltrans Mockup	

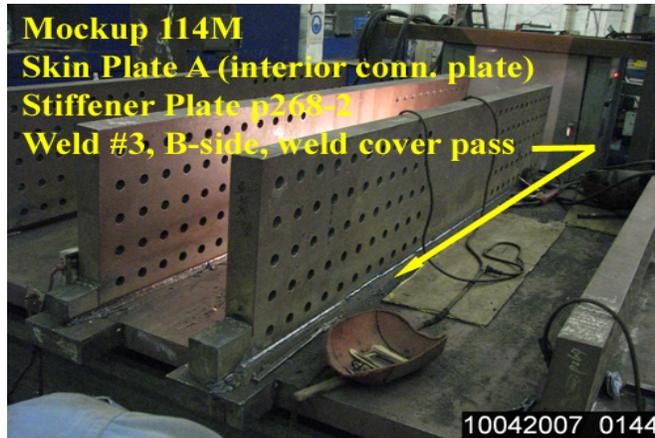
Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M and 114M, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate A (interior conn. plate)	NA	NA	Completed weld.
	Mock-Up 114M, Skin Plate A (interior connection plate): Caltrans QA Inspector observed flux cored arc welding (FCAW) in progress at stiffener plate, p268-2, weld map weld number 3, B side to skin plate A58, complete joint penetration (CJP), double bevel T-joint weld. The welder was observed welding cover pass weld in the horizontal position. The welder is identified as Mr. Chang Chuancang, welder stamp 053870. The welder is using welding procedure specification WPS-B-T-2232-TC-U5-F, Revision 1. Caltrans QA Inspector observed ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Xu Lefeng and Bureau Veritas inspector, Mr. Hou Jing Tao monitoring welding activities at the workstation. Caltrans QA Inspector measured current welding parameters at approximately 290 amps, 31.5 volts and 320 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. The preheat temperature prior to the start of welding measures more than 110 Celsius (230 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. FCAW consumable is verified and identified as Supercored 71H, classification E71T-1, diameter 1.4 mm (.052 inches). The following digital picture illustrates completed cover pass weld.			

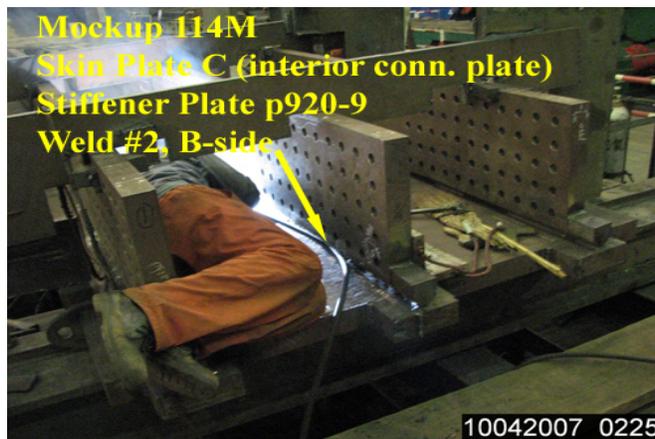
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2 Skin Plate C (interior conn. plate) NA NA Work in Progress

Mock-Up 114M, Skin Plate C (interior connection plate): Caltrans QA Inspector observed flux cored arc welding (FCAW) in progress at stiffener plate, p920-9, weld map weld number 2, B side to skin plate A67, complete joint penetration (CJP), double bevel T-joint weld. The welder was observed welding fill pass weld in the horizontal position. The welder is identified as Mr. Jiang Zhou, welder stamp 040261. The welder is using welding procedure specification WPS-B-T-2232-TC-U5-F, Revision 1. Caltrans QA Inspector observed ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Xu Lefeng and Bureau Veritas inspector, Mr. Hou Jing Tao monitoring welding activities at the workstation. Caltrans QA Inspector measured current welding parameters at approximately 300 amps, 31.5 volts and 350 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. The preheat temperature prior to the start of welding measures more than 110 Celsius (230 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. FCAW consumable is verified and identified as Supercored 71H, classification E71T-1, diameter 1.4 mm (.052 inches). The following digital pictures illustrate welding in progress.



Summary of Conversations:

At 0230 hour, ZPMC QC inspector, Mr. Ley Tao informed Caltrans QA Inspector that welding would be stopped at 0330 hours. No further explanation was given other than the welders were not going to work past the 0330 hour.

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

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for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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