

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-000608**Date Inspected:** 11-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**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:** Sha Zhi**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:** 89 Meter Mock-Up**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 89 Meter Mock-Up Plate MP513-1 to MP509-1 Filler welding being deposited by certified welder Wu Zhibin #049804. Welding parameters recorded by this QA Inspector were, Amps 629 and 632, Volts 32.4 and 31.4, Travel Speed 600 and 625 mm/min. and the temperature measured at 144c. The welding procedures are as follows, WPS-B-T-2221-B-U3C-S(CJP) and WPS-B-T-2321-B-P3-S(PJP).

Item-2 89 Meter Mock-Up Skin Plate C Lower Section. The run off tabs were removed from the plates edges, MP507-1 to MA23-1 and MP508-1 to MA23-1, at each of the weld seams and were being ground smooth by a Zhenhua Port Machinery Company employee.

Summary of Conversations:

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

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: Smith, David

Quality Assurance Inspector

WELDING INSPECTION REPORT

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Reviewed By: Cochran,Jim

QA Reviewer