

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000610**Date Inspected:** 11-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:** Zhu Zhong Hai**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:**

This Quality Assurance (QA) Inspector observed ZPMC welder Han Cheng Hao, welder identification 059464 welding in the flat groove weld position (1G) on the 89 Meter Mock-Up, MUSB MA-23-1 to mp 508-1 of Skin Plate Sub-Assembly Face "C". Welding was being carried out to welding procedure specification (WPS) WPS-B-T-2321-b-P3-S-1 using the submerged arc welding process (SAW). The weld numbers were 21B for the root of the complete joint penetration weld (CJP) and weld number 3 for the partial penetration joint weld (PJP). The essential variables were checked by the quality control inspector (QC) and the voltage was found to be 30 and the amperage 485. Preheat was measured and found to be 160 degrees Celsius (C).

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician, Cai Xinxin testing the root pass weld on the 89 Meter Mock-Up, MUB MA22 Skin Plate Sub-Assembly (Face D). This was a partial joint penetration (PJP) weld, joint number 18 between plates MA22-1 and mp506-1. The piece was turned over and the PJP root weld, number 17 on the B side was MT tested as well. Mr. Cai reported finding no relevant indication during testing and accepted the weld. 10% QA verification MT was conducted on root weld for the PJP weld joint 18, for details see TL-6028 dated October 11, 2007.

Summary of Conversations:

No significant conversations held today.

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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer