

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-000629**Date Inspected:** 12-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Lujian Bing**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 Mock-up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the welding of the Caltrans Mock-up # 89.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing Submerged Arc Welding (SAW) welding at Mock-up # 89.00 Skin Plate D sub assembly MA1 weld # 3. ZPMC QC inspector Mr. Xu Le Feng, monitored welding operations. Certified welder Han Chang Hou performed welding. Inter-pass cleaning was performed by ZPMC personnel and appears to be in general conformance with AWS D1.5 requirements. Welding procedure utilized was WPS-B-T-2221-B-U-U3c-S and WPS- B-T-2321-B-P3-S with the following welding parameters noted, amperage 624, voltage 32.4, travel speed 600.

Caltrans QA Inspector observed ZPMC QC technicians performing dimensional measurements of 10 meter closed ribs. ZPMC QC personnel were noted taking measurements of longitudinal straightness and profile measurements with a template as seen in the digital picture below on closed rib U21.

Caltrans QA Inspector observed that the welding and dimensional testing above appeared to be in general conformance with AWS D1.5 2002 requirements.

WELDING INSPECTION REPORT

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Summary of Conversations:

As Identified within contents of this report.

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:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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