

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-000631**Date Inspected:** 11-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi, Hua Li Wei**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 Mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fitup, welding and related activities associated with the fabricating of 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.

Item	Description	WBS	Dwg No.	Status
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1	Mock-Up 89.00, skin plate D (upper)			welding of plate mp509 t
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Caltrans QA Inspector observed submerged arc welding (SAW) in progress at skin plate mp509 to mp513, MUSB-MA22 splice welds. The weld joints are Complete Joint Penetration (CJP) and Partial Joint Penetration (PJP), double bevel butt-joint. The welder is observed welding fill and cover passes in the 1G position using a chipping hammer and wire brushing during interpass weld cleaning. The approved welder is identified as Mr. Wa Zhi Bing, welder stamp 049804. The welder is using welding procedure specification WPS-B-T-2221-B-U3C-S for the CJP weld and WPS-B-T-2321-B-P3-S for the PJP weld. Caltrans QA Inspector observed ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi and Bureau Veritas Inspector, Mr. Hua Li Wei monitoring welding activities at the workstation. Caltrans QA Inspector observed current welding parameters at approximately 610 amps, 32 volts and 620 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. SAW welding consumable is verified and identified as classification EM12K, JW-3, diameter 4.8 mm (.188 inches) using JF-B flux.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As identified within the 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: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer