

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-000632**Date Inspected:** 12-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:** 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:**

This Quality Assurance (QA) Inspector observed ZPMC welder Han Xiaofeng, welder identification 054467 welding in the flat groove weld position (1G) on the 89 Meter Mock-Up, MUSB MA-38-1 to mp 502-1 of Skin Plate Sub-Assembly Face "E". Welding was being carried out to Welding Procedure Specification (WPS) WPS-B-T-2311-b-P3 using the Submerged Arc Welding (SAW) process. The weld number 15 is for the root of the Complete Joint Penetration (CJP) weld. The essential variables were checked by the Quality Control (QC) inspector and the voltage was found to be 33.7, the amperage 642 and the travel speed 615 millimeter per minute. Preheat was measured and found to be 170 degrees Celsius (C).

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician, Zhou Dong Yun testing the 3000 mm long root pass weld on the 89 Meter Mock-Up, MUB MA38 Skin Plate Sub-Assembly (Face E). This was a Partial Joint Penetration (PJP) weld, joint number 15 between plates MA38-1 and mp502-1. Mr. Zhou 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 15, for details see TL-6028 dated October 12, 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 for your project.

WELDING INSPECTION REPORT

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Inspected By:	Berger, Bruce	Quality Assurance Inspector
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Reviewed By:	Cochran, Jim	QA Reviewer
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