

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-000650**Date Inspected:** 19-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:** Shi 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 Corner Splice Plate MUB-MA21F/J-9B. Welding of the filler passes was being performed by Zhenhua Port Machinery Company (ZPMC) certified welder Wang Zhonghua #053753. The welding procedures utilized was WPS-B-T-3211-TC-U5b using welding rods 9018M-H4R. A rod box was used to maintain the specified temperature for the welding rods. The CWI present was Shi Zhi. The welding parameters recorded by this QA Inspector were, Amps 189, Volts 24.5, Travel Speed 120mm/min. and the Temperature was 165c.

Item-2 89 Meter Mock-Up, Skin Plate-B Stiffener plate #MP531-1 to plate #MA24-1 The (ZPMC) A dry powder Magnetic Particle (MT) test was witnessed on two root welds by this Caltrans QA Inspector and was being performed by the Level II MT technicians Cai Xin Xin for weld #3 and Zhou Dong Yun for weld #4 for which no relevant indications were noted. The Caltrans QA Inspector performed an MT test on areas of welds 3 and 4 and found them to be in compliance with project specifications. CWI present was Xu Le Feng.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Smith,David	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Cochran,Jim	QA Reviewer
---------------------	-------------	-------------