

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-000651**Date Inspected:** 18-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:** Xu Xian Ping**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:** Closed Rib Trial**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 Meter Mock-Up Corner Splice Plate #MUB-MA21F/FJ-10A to SA24-2/P913-2, the material was 485 and the thickness was 75mm. Shielded Metal Arc Welding was being performed in the 1G position utilizing welding rods 9018 M-H4R by certified welder (A) Dai Lu #048659 and welder (B) Wang Zhonghua #053753.

Welding parameters recorded by this QA Inspector for each welder were, (A) Amps 199, Volts 24.1, Travel Speed (T/S) 140mm/min. temperature 200c and welder (B) Amps 195, Volts 24.4, T/S 112mm/min. with a temperature of 190c. Once the welding had stopped a visual showed areas which required further grinding before welding could continue.

Item-2 Closed Rib Trial Welding Parameters Control. As assigned by Lead Caltrans QA Inspector Bruce Burger this Caltrans QA Inspector did stay at the top of the welding units monitoring the voltage for four welding machines. The welding machine performing the weld on Rib U-74 weld 3 machine S/N 058801465, weld 4 machine S/N 058807473, Rib U-104 weld 7 machine S/N 058801470 and weld 8 S/N 058801471. The QC present and documenting the voltage was Huang Min and the CWI was Xu Xian Ping.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Smith,David | Quality Assurance Inspector |
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| Reviewed By: | Cochran,Jim | QA Reviewer |
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