

**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-000664**Date Inspected:** 22-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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:** Zhu Zhong Hai**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:** Mock Up**Summary of Items Observed:**

Elevation 89:

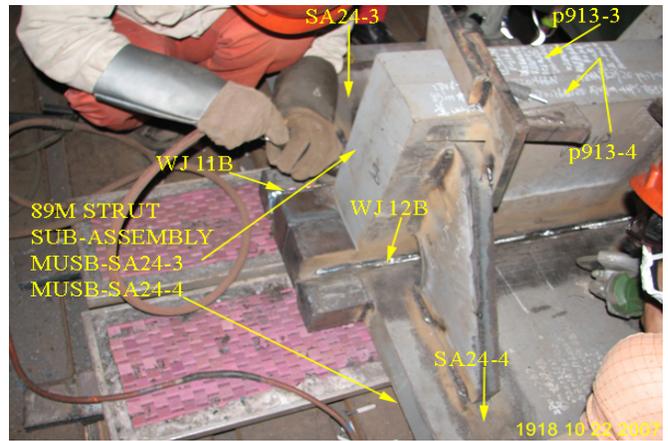
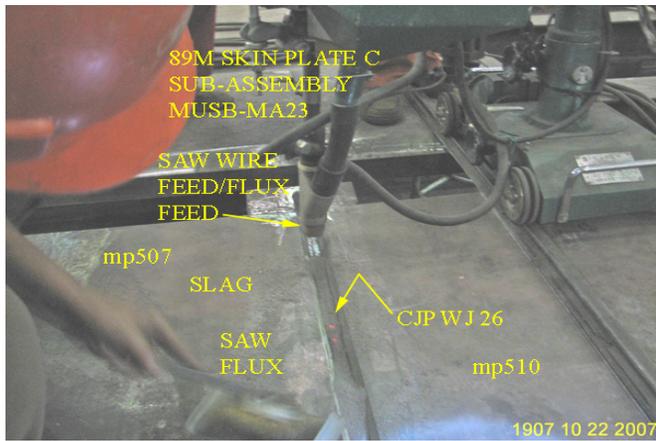
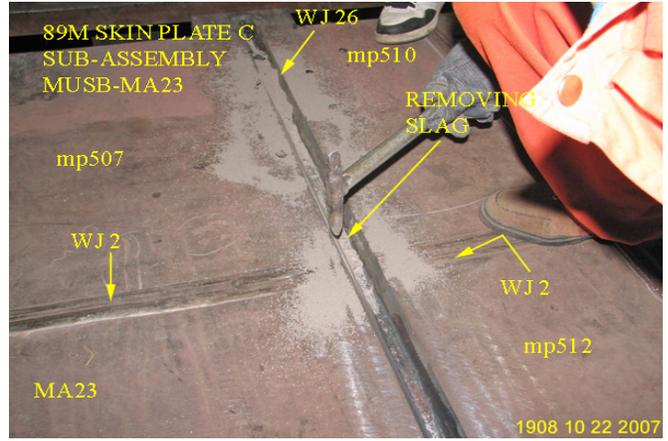
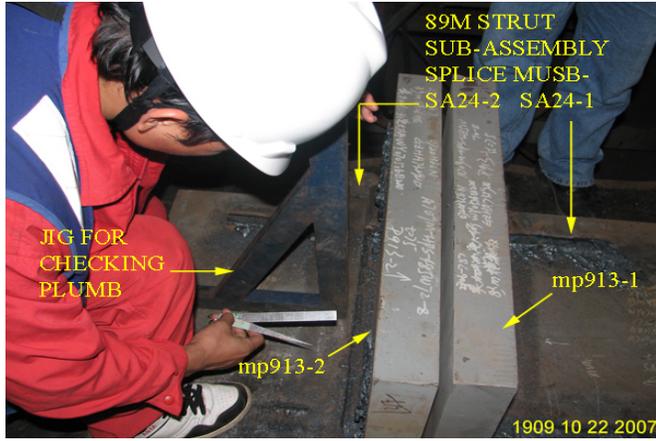
The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the fabrication of the Mock Up. The QA Inspector randomly observed welding being performed for the fabrication of the Mock Up at Elevation 89M. The QA Inspector randomly observed ZPMC qualified welder Wu Zhibin utilizing the Submerged Arc Welding (SAW) process to place the root and hot pass on Skin Plate C, SA MUSB-MA23, WJ 26. Mr. Wu was utilizing ZPMC approved Weld Procedure Specification (WPS) WPS-B-T-2221-B-U3C-S-1. The QA Inspector observed ZPMC CWI Zhu Zhong Hai monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows: welding amperage 490 amps, welding voltage 30 volts with a travel speed of 450 millimeters per minute. Weld parameters appeared to comply with the above approved ZPMC WPS. The attached photographs provide additional detail.

The QA Inspector randomly observed ZPMC Quality Control (QC) personnel checking the plumb on 89M Strut Sub-Assembly MUSB-SA24 splice plates piece marks MUB-SA24-1 and MUB-SA24-2. The attached photographs provide additional detail.

The QA Inspector randomly observed ZPMC welding personnel cleaning up Weld Joint (WJ) numbers 11B and 12B on 89M Strut Sub-Assembly MUSB-SA24 splice plates piece marks MUB-SA24-3 and MUB-SA24-4. The attached photographs provide additional detail.

# WELDING INSPECTION REPORT

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## Summary of Conversations:

There were no relevant conversations.

## 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:** Franco,Charlie

Quality Assurance Inspector

**Reviewed By:** Cochran,Jim

QA Reviewer