

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-000680**Date Inspected:** 24-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:** Xu Le Feng**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.

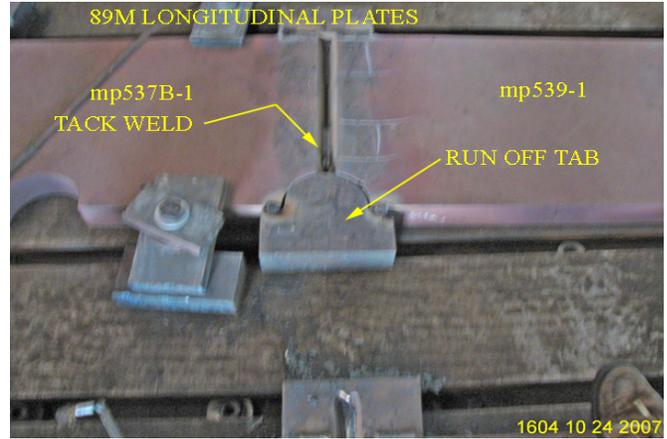
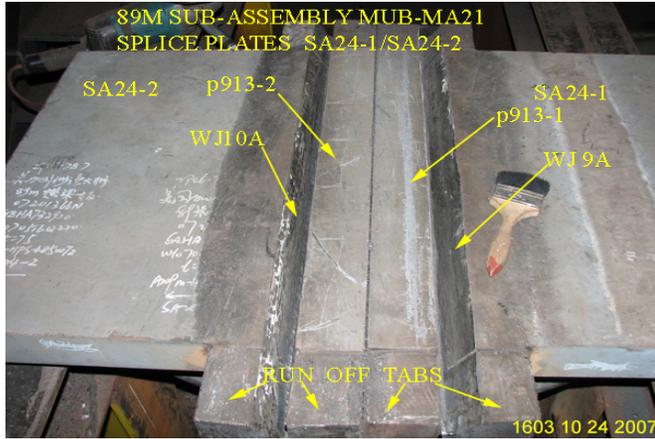
The QA Inspector randomly observed a ZPMC helper utilizing a grinder to clean up and blend Complete Joint Penetration (CJP) Weld Joint (WJ) numbers 9A and 10A on 89M Sub-Assembly (SA) MUB-MA21, splice plates piece marks SA24-1 and SA24-2 after back gouging with carbon air arc. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Han Xiaofeng, utilizing the Shielded Metal Arc Welding (SMAW) process with approved ZPMC Weld Procedure Specification (WPS) WPS-B-P-2211-B-U3b, to attach run off tabs to longitudinal plates piece marks mp533A-1, mp533B-1, mp533C-1, mp537A-1, mp537B-1 and mp539-1.

The QA Inspector randomly observed ZPMC welder Han Xiaofeng, utilizing the Shielded Metal Arc Welding (SMAW) process with approved ZPMC WPS WPS-B-P-2211-B-U3b to place tack welds between longitudinal plates piece marks mp533A-1 to mp533B-1, mp533B-1 to mp533C-1, mp537A-1 to mp537B-1 and mp537B-1 to mp539-1. The attached photograph provides additional detail.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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