

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-000683**Date Inspected:** 21-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 Li Feng & Ye Yong Jun	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;

SAS Tower Mock Up:

Item-1 89 Meter Mock-Up, Skin Plate-B weld #1, cover pass weld of stiffener plate MP531-2 to bottom plate #MA24-1. Two welders performing the Flux Core Arc Welding (FCAW) were welder (A) Sun Tiyu #054459 and welder (B) Li Shuliang #048801. The two welders with Zhenhua Port Machinery Company (ZPMC) are certified for Flux Core Arc Welders (FCAW) in the 3G position. The welding parameters recorded by this QA Inspector were, welder (A) Amps 290, Volts 29.5, Travel Speed (T/S) 295mm/min. Temperature (Temp.) 130c and welder (B) Amps 290, Volts 29.5, T/S 290 and (Temp.) 130c. Once the preheat temperature were in accordance with the project specifications welder (B) was monitored and welding parameters were recorded at Amps 300, Volts 31.5 and T/S 300mm/min. The welding wire used for these two welders was Supercored 71H and the welding procedure was WPS-B-T-2332-TC-P5F. The CWI present was Ye Yong Jun and QC Ma Qian Li.

Item-2 89 Meter Mock-Up Skin Plate-C Plates MP511-1, MP512-1 and MP510-1 welded to MP507-1, MA23-1 and MP508-1. The PJP joint was weld #26. Tack welding of this joint was observed as the ZPMC welder Han Xiao Feng # 054467 certified as Shielded Metal Arc Welding (SMAW) in the 3G position used welding rods TL508. During the time this Caltrans QA Inspector was present the welding rod box was not plugged in to maintain the proper temperature as required by the project specifications. The CWI present was Xu Le Feng and the QC was Xu Jinglong. The welding procedure utilized was WPS-B-P-2211-B-U3b.

Summary of Conversations:

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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.

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