

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-000693**Date Inspected:** 22-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi, Li Wen Sheng**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:** Caltrans Mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up 89.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Strut Assembly			In Progress
	<p>Caltrans QA Inspector observed SMAW in progress of root pass on plates P913-3 to SA24-3 and P913-4 to SA24-4 welds 11B, 12B MUB-MA21. The weld joint is a Complete Joint Penetration (CJP) double bevel T-joint in the 1G position. The approved welders Dai Lu # 048659 welding 11B and Wang Zhon Hua welding 12B were using approved welding procedure specification WPS-B-T-3211-TC-U5B. Caltrans QA Inspector observed current welding parameters at approximately 247 amps, 24.6 volts and 132 millimeters per minute (mm/min) travel speed. Preheat and interpass temperatures were verified during welding activities. The preheat temperature prior to the start of welding measures more than 110 Celsius (230 degree Fahrenheit) but less than 232 Celsius (450 degrees Fahrenheit) during maximum interpass temperature verification. SMAW welding consumable is verified and identified as classification E9018 H4R Excalibur 4.8mm diameter. An electrode oven was observed by Caltrans QA Inspector in use during the welding process. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Sha Zhi and Bureau Veritas Inspector Mr. Li Wen Sheng were observed monitoring welding activities at the workstation.</p>			

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

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:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
