

**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-000712**Date Inspected:** 28-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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:** Xu Le Fen**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:** longitudinal stiffener**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Timothy McClendon was present to observe Welding of the 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.

QA Inspector, Timothy McClendon accompanied with ZPMC QC Shen Xun jun randomly observed a full penetration weld joint, weld number MUS B -MA 22A/B M- 16, on face D of mock-up 89 longitudinal plate stiffeners plate numbers MP 535A-1 to MP535B-1, being welded with the FCAW process. ZPMC welder, Li Zhao Qian certification number 048810 was using the FCAW process, using welding procedure WPS-B-7-2231-B-V3-F. QA Inspector, Timothy McClendon observed and verified ZPMC QC An Qingxi ang recording weld parameter Amps 309, Volts 31.3, Travel Speed 307 mm/min, and the Temperature was 135C.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations spoken on this day.

## 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.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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