

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-000714**Date Inspected:** 29-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:** Ye Yongjun**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:

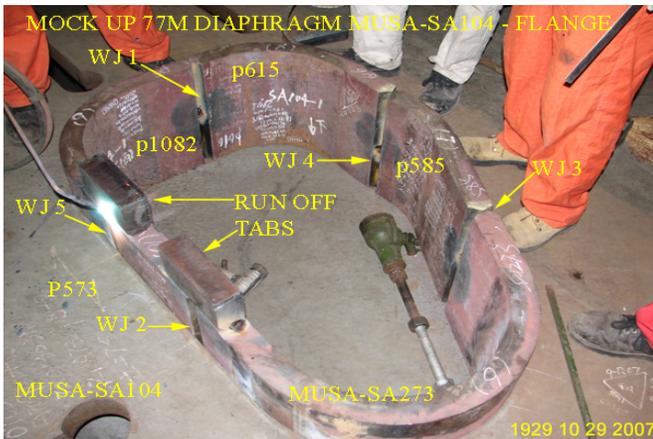
The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the fabrication of the Mock Up.

The QA Inspector randomly observed ZPMC welder Yang Lei ID Number 040690, with the assistance of other ZPMC welding personnel attaching run off tabs and fitting up and tack welding in place, the reinforcing flange MUSA-SA274 of 77M Diaphragm MUSA-SA95. Mr. Yang was utilizing ZPMC Weld Procedure Specification (WPS) WPS-B-P-2112 for the run off tabs, and WPS WPS-B-P-2213-B-U3b for the tack welding of the reinforcing flange sections. The following photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Zhai Qingshan, with the assistance of other ZPMC welding personnel attaching run off tabs and fitting up and tack welding in place, the reinforcing flange MUSA-SA273 of 77M Diaphragm MUSA-SA104. Mr. Zhai was utilizing ZPMC Weld Procedure Specification (WPS) WPS-B-P-2112 for the run off tabs, and WPS WPS-B-P-2213-B-U3b for the tack welding of the reinforcing flange sections. The following photographs provide 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
