

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000718**Date Inspected:** 25-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:** Changxing Island**CWI Name:** Shai Zhi**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 89 and 114**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Welding operations and of the Caltrans Mock-up # 89.00 and Heat Shaping of 77.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC shop personnel performing Flux Core Arc Welding (FCAW) at Mock-up # 89.00 Skin Plate C sub assembly MA23 longitudinal plate Complete Penetration Joint (CJP) weld # 11 and 12. ZPMC QA inspector Fu Yuhong stated that the welding procedure for the above mentioned weld joints was WPS-B-T-2231-B-U3-F. Caltrans QA Inspector Viars recorded the following welding variables for weld joint # 12, amperage 308, voltage 30.8, with a travel speed of 312.

Inspector Viars monitored the MT of Mock-up # 114.00 sub assembly MA111 weld joint # 5 excavation area. ZPMC QC Mr. Cai Xin Xin performed the MT of the excavation area and found the area to be acceptable to AWS D1.5 requirements. The following picture illustrates Mr. Cai Xin Xin performing MT of the above mentioned excavation area.

ZPMC performed CNC automated thermal cutting of plate # NG070524G191, batch # 071008800202, material 345T2-X.

The Caltrans QA Inspector monitored welding operations of Mock-up # 89.00 Skin Plate C and performed Magnetic Particle Testing of Mock-up 114.00 Skin Plate C weld # 5. Caltrans QA Inspector observed that the welding and magnetic Particle Testing appeared to be in general conformance with AWS D1.5 2002 requirements.

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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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
