

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-000723**Date Inspected:** 31-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:	Ye Yong Jun & Xu Le Feng			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 Mock-Up		

Summary of Items Observed:

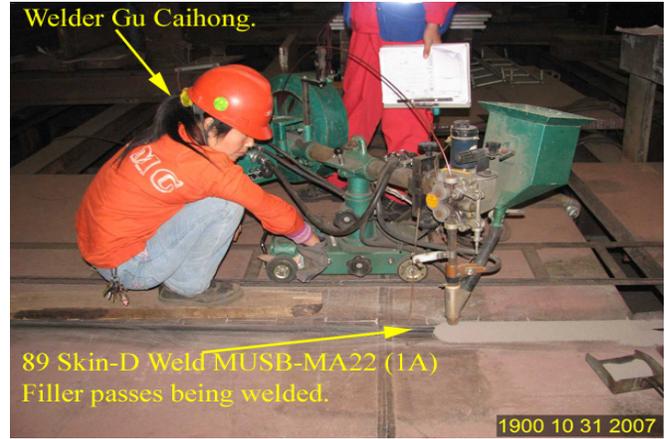
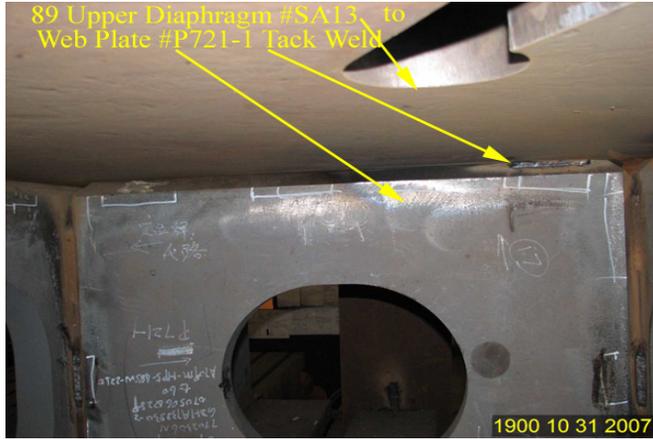
On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up Skin-D weld MUSB-MA22 (1A). Zhenhua Port Machinery Company (ZPMC) welder Gu Qaihong #053748 certified for Shielded Arc Welding (SAW) in the 1G position was observed welding filler passes while utilizing welding wire Jin-3 (0.48mm/dia.)/JF-3. The procedure used was WPS-B-T-2221-B-U3C-S and the welding parameters recorded by this QA Inspector were, Amps 651 & 633, Volts 32.5 & 33.7, Temperature 126c & 120c and the Travel Speed was measured to be 610mm/min. The thickness of the 345 material was 60mm/60mm and 90mm/90mm. The CWI present was Xu Le Feng and the QC was Xu Jing Long.

Item-2 89 Meter Mock-Up Upper Diaphragm #SA13 was having the Web Plates #P720-1, P138-1, P721-1 and P842-1 tacked.

WELDING INSPECTION REPORT

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Summary of Conversations:

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