

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-000724**Date Inspected:** 30-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 Yeng 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 Lower Diaphragm P213 and Upper Diaphragm SA13. Tack welding of the web plates P720-1 & P138-1 to the lower diaphragm plate P213 was in progress. Welding was being performed by three certified Shielded Metal Arc Welders (SMAW) welders, Wang Zhonghua #053753, Han Xiaofeng #054467 & Dai Lu #048659. The welding procedure used was WPS-B-T-3312-TC-P5 and the welding rods utilized were 9018M H4R which were kept in a hot rod oven box. Welding parameters recorded by this QA Inspector were, Amps 180, Volts 22.97 and the temperature of the base material adjacent to the weld was greater than 120c within two minutes after welding had stopped. The CWI that was present was Ye Yeng Jun and the QC was Ma Qianli.

Item-2 89 Meter Mock-Up, Skin-D, weld MUSB-MA22 (1B). Filler passes were being deposited by welder Gu Caihong #053748 certified in the 1G position with Shielded Arc Welding (SAW). The welding procedure used was WPS-B-T-2221-13-U3C-S AND THE WELDING WIRE UTILIZED WAS JIN-3 (0.48MM/dia.)/JF-B. The plates being welded together were of 345 material and 90mm thick plate #MP506-1 to MP509 and 60mm thick which were #MP513 to MA22. The welding parameters recorded by this QA Inspector were, Amps 634, Volts 33, Temperature 115c and the Travel Speed was measured at 610mm/min. The CWI present was Xu Le Feng and the QC was Xu Jing Long.

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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