

**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-000738**Date Inspected:** 31-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 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 Skin plate D**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Item-1 89 Meter Mock-Up Skin-D, Drawing number MUSB-MA22B/B, Weld number 1B, member ID numbers mp509-1, mp513-1, mp508-1 and mp22-1. Zhenhua Port Machinery Company (ZPMC) welder Gu Qaihong #053748 certified for Submerged 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 650 & 635, Volts 31.5 & 32.5, Temperature 124c & 122c 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 Cutting of 12mm diaphragm plates drawing number 12/1206mp for OBG by computer numerical controlled (CNC) machine.

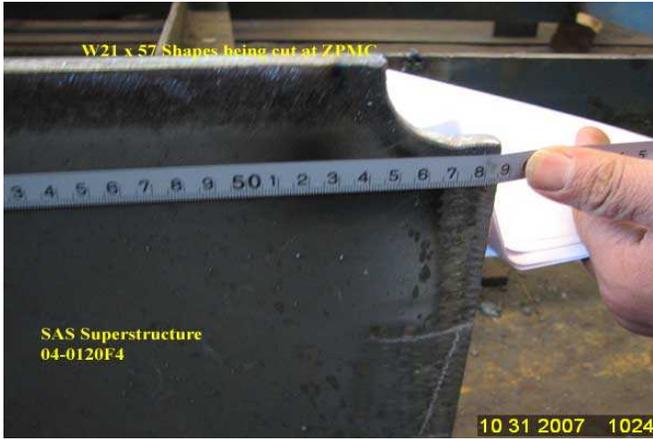
Item-3 Cutting W21 x 57 shapes drawing numbers RS9C and RS9D. QA inspector observed ZPMC QC perform dimensional inspections and also personally performed random dimensional inspection. It appears dimensions are within tolerances of drawings.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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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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**Inspected By:** McClendon, Timothy Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert QA Reviewer