

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-014043**Date Inspected:** 13-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	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:****Summary of Items Observed:**

Welding of ED1-A27B/B-35. The welder was identified as 040581. The welding procedure was identified as WPS-B-T-2311-Tc-P6. The ZPMC QC was identified as Li Peng Fei. The ZPMC CWI was identified as Li Lin.

Welding of section 7EW to 7DW at CA043-005. The welder was identified as 037840. The Welding procedure was identified as 037840. The ZPMC CWI was identified as Li Lin.

Welding of section 7EW to 7DW at CA044-001. The welder was identified as 037840. The Welding procedure was identified as 037840. The ZPMC CWI was identified as Li Lin.

This inspector performed a production monitoring test, PMT, on deck panel on a 500mm, 3 rib specimen to qualify the welding machine and welders to weld deck panels DP3119-001, and DP3120-001. The welding procedure was identified as WPS-B-T-2342-U1(U-rib)-5. The preheat for the welding operations was noted to be 60C or above at the time of welding. This inspection was in conjunction with ZPMC CWI Chen Shigang, and ABF QC Cao Haizhou. The welders noted on Gantry welder 1 in bay 9 are as follows:

202452

059148

059421

059416

201788

203805

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

059378

15 macro samples were marked for testing by this inspector. Samples were cut and polished by ZPMC personnel and given to this inspector for verification after acceptance by ZPMC and ABF QC personnel. Results from all macro etch samples were acceptable. A production monitoring test report was generated for this test, and date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine, Daniel	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
