

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 #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000139**Date Inspected:** 30-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

Quality Control Contact: Zhu Zhonghai
Material transfer: Yes No N/A
Stock Transfer: Yes No N/A
Rebar Test Witness: Yes No N/A

Quality Control Present: Yes No
Sampled Items: Yes No N/A
OK to Cut: Yes No N/A
Delayed/Cancelled: Yes No N/A

Other: N/A**Bridge No:** 34-0006**Component:** 77 Meter Mock-Up**Bid Item:** 52 (SF)**Lot No:** N/A**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon 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.

This QA Inspector witnessed the in process welding of 77 Meter Mock-Up MUSA-SA273 inside weld joint # 4 between piece marks identified as p585 and p615 also weld joint # 5 between piece marks p573 and p1082. The ZPMC Certified Welding Inspector (CWI) Zhu Zhonghai informed the QA Inspector the approved welding procedure specification WPS-B-T-223-B-U3-F was being followed to perform the welding.

The ZPMC approved qualified welder Wong Bing ID # 048696 was utilizing Flux Cored Arc Welding (FCAW) process in the vertical (3G) position with the 1.4 mm diameter electrode designated as E71T-1 /AWS A5.20, brand name Supercored. This QA Inspector observed the ZPMC Quality Control (QC) personnel Zhang Giao check the welding machine amperes at 205 and 24 volts using a voltage meter, This QA Inspector Dixon also performed random verification of the weld parameters using a Fluke meter.

This QA Inspector witnessed the in process welding of 77 Meter Mock-Up MUSA-SA274 inside weld joint # 4 between piece marks identified as p585 and p615 also weld joint # 5 between piece marks p573 and p1082. The ZPMC Certified Welding Inspector (CWI) Zhu Zhonghai informed the QA Inspector the approved welding procedure specification WPS-B-T-223-B-U3-F was being followed to perform the welding.

This QA Inspector visually verified the above listed approved WPS, which was posted near the welding operation

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and determined that the welding and work in progress on the items listed above appeared to comply with WPS and the contract documents. See photographs below to provide additional detail.



Summary of Conversations:

As noted above and basic communication between QC Inspector and QA inspector when and where welding inspections are to be performed.

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: Dixon, Roscoe

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer
