

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-000035
Date Inspected: 09-Dec-2006

Project Name: SAS Superstructure **OSM Arrival Time:** 800
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1500
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Liu	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:	N/A	

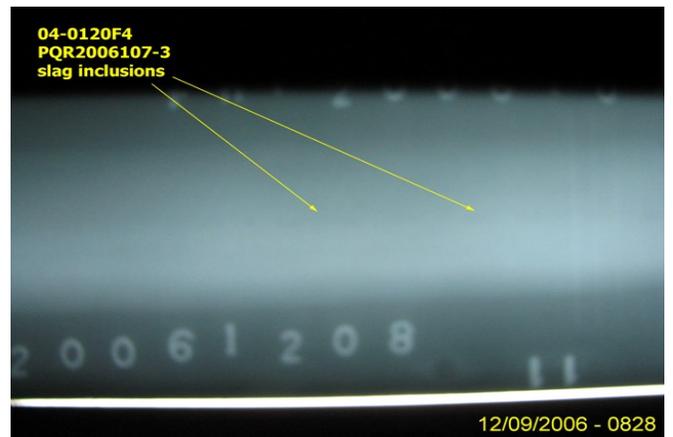
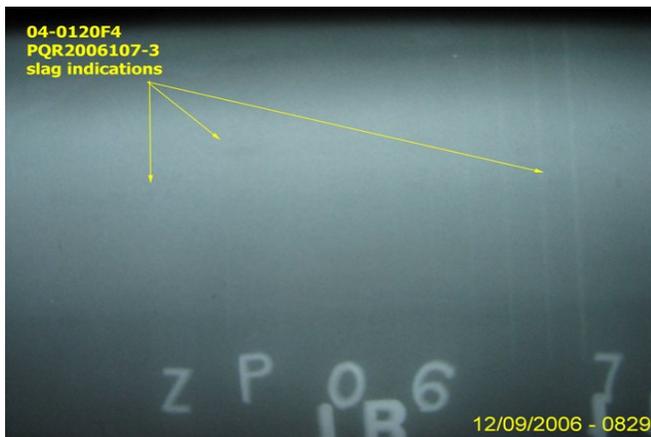
Summary of Items Observed:

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge

Item	Description	WBS	Dwg No.	Status
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1

The QA Inspector did not observe welding on this date, but was asked to review radiographic film for PQR 2006107-3. The weld was not in compliance due to inclusions in the weld as shown below in photos. See QA's TL-6032 for details.



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

2

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The QA Inspector informed the QC Inspector that the film station markers were not correct and that corrections should be made before production starts. The film markers were not properly placed and the lap of station markers was incorrect. The QC inspector Mr. Liu Liu was shown the problem with the film. The weld quality did not comply for this PQR. It was explained to the QC that this would be a problem in production for the X-ray technique being unsatisfactory with concerns on markers for the welds.

The ZPMC QC Manager Mr. Liu Liu stated that he would like to run a PQR for the HPS 485W steel on this date. The QA Inspector contacted the Quality Control Manager (QCM) Mr. Jim Bowers to inform him that the plant wanted to perform the above mentioned test.

Summary of Conversations:

The QC Inspector with ZPMC Quality Control (QC) stated that they would be running more practice plates for the PQR 2006107-4. The QC stated that the parameters on PQR2006107-4 would be lowered and trials would be run again before contacting the QA Inspector for witnessing.

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:	Wright,Mark	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
