

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-000074**Date Inspected:** 09-Feb-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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.

The Caltrans Quality Assurance (QA) Inspector was present to observe the internal mockup done by ZPMC at their facility. The QA Inspector observed several potential problems with the welding performed on the mockup. Weld terminations would have to be addressed during production.

The Caltrans QA Inspector also toured the closed rib production site at ZPMC and observed the plate milling machine and the plate beveling machine as shown in the photos below. The ZPMC representative explained the the process would be assembly line type work, with the squaring of the plate followed by the beveling and then the ribs will be form and placed on a panel which will be placed inside of a prebend jig for welding of the closed ribs as shown in the photos below.

WELDING INSPECTION REPORT

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Summary of Conversations:

See Task Leader journal for this date.

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