

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-000078**Date Inspected:** 01-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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:	NA	

Summary of Items Observed:

The CALTRANS Quality Assurance (QA) Inspector, Mr. Mike Hasler was present for the welding qualification testing pertinent for the welding qualification record (PQR) HP200706 scheduled for this project. Caltrans Quality Assurance (QA) Inspector assisted Caltrans QA Inspector, Mr. Alfredo Acuna in witnessing the testing. See Caltrans QA Inspector, Mr. Acuna's Welding Inspection Report (TL6031) and Welding Witness Report (TL6032) for additional information, dated 03-01-2007.

Summary of Conversations:

ZPMC, Quality Assurance (QA) Inspector, Mr. Hu Gang informed Caltrans that ZPMC would be performing procedure qualification (PQR) testing for HP200706 and HP200707. Caltrans QA Inspectors, Mr. Alferdo Acuna and Mr. Mike Hasler arrived at ZPMC's testing facility to witness the PQR testing for HP200706 and HP200707. With Mr. Acuna witnessing HP200706 and Mr. Hasler witnessing HP200707. Caltrans QA inspector observed HP200707 test plate's over-all width is not in accordance with AWS D1.5 Figure 5.1 requirements. The measured width of the test plate appeared to be 20 mm undersize. Caltrans QA informed ZPMC QA Manager, Mr. Liu Liu of the discrepancy. Mr. Liu Liu confirmed the findings and stated that he would have ZPMC fitup another test plate to replace this one. Mr. Liu Liu terminated the welding of the test plate and stated that testing of PQR HP200707 would be resumed tomorrow. Mr. Hasler met with Mr. Acuna to assist him in his witnessing of the PQR testing.

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.

WELDING INSPECTION REPORT

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Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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