

**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-000911**Date Inspected:** 22-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Fu Guo Gang			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	77 & 89 meter tower mock ups		

**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up fabrication and production of the SAS Superstructure.

Bay 2: The QA inspector made random observations of work in progress on the 77 meter mock up section and the 89 meter tower mock up section. The QA inspector witnessed the ZPMC technician Zhou Dong Yun conducting magnetic particle testing (MT) on partial joint penetration (PJP) tack welds between the diaphragm plate SA-95 and web plates P576, P579, P720 & P721. The QA inspector was informed that MT will not be completed during this shift.

The QA inspector observed Bureau Veritas personnel conducting flatness checks of 89mm skin plate sections.

The QA inspector also observed ZPMC workers preparing to weld on the 89 meter skin plate assembly MA38 A/B.

The QA inspector noted that the Quality Control (QC) inspector Fu Guo Gang is an approved CWI and will be monitoring the work at this location. The QA inspector also noted and reported on 11-21-2007, the form being used for the electrode/flux storage and tracking appears to be different than the sample form that is presented in the approved welding quality control plan. See the attached photos.

