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-001153
Date Inspected: 31-Dec-2007

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1400
OSM Departure Time: 2330
Location: Shanghai, China

CWI Name: Cui Yi Rui

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower Mock Ups, OBG components

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 construction and production construction of the SAS Superstructure.

Bay 3: The QA inspector observed ZPMC technician Zhou Dong Yun conducting partial magnetic particle testing (MT) on SP075-01, T-stiffener fillet welds #016 through #027. The QA inspector was informed that the MT was completed and the welds were acceptable. The QA inspector noted that MT Accept is written on the stiffeners. The QA inspector conducted random visual examination of the completed and accepted fillet welds. The QA inspector noted that base metal of the side plate (SP) appears to have been ground to a depth that exceeds 1.0mm at the weld access hole of fillet welds 018/019. The QA inspector also noted that the fillet welds are wrapped around the weld access hole of the T-stiffeners and where the welds transition, there appears to be undercutting and sharp notches in the base metal of the T-stiffeners. The QA inspector observed that the welds do not appear to be visually conforming to the contract requirements at this time and no MT verification was conducted. See the attached photos.

Bay 7: The QA inspector observed ZPMC personnel using submerged arc welding (SAW) on FB025-01 to weld joints 078 and 101. The QA inspector identified the welding machine operators as Wang Min and Huang Xin Lan. The QA inspector noted that the welding is being monitored by several other ZPMC personnel. The QA inspector observed Xiang Feng monitoring the preheat temperature and welding parameters and recording this information on a welding report. The QA inspector reviewed the list of approved CWI/CAWI and could not identify this person as an approved Quality Control (QC) person. The QA inspector noted that the approved Lead CWI Cui Yi

WELDING INSPECTION REPORT

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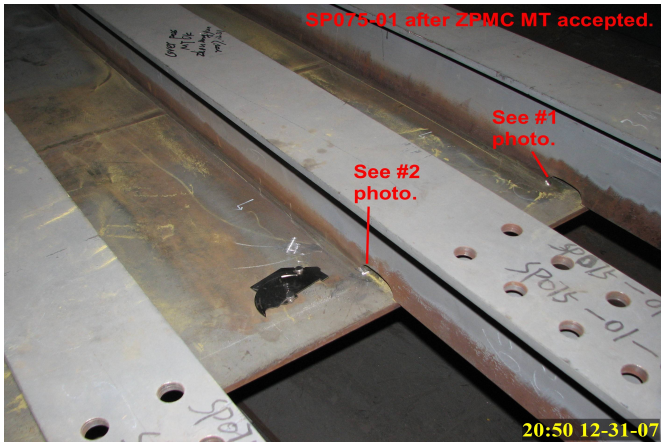
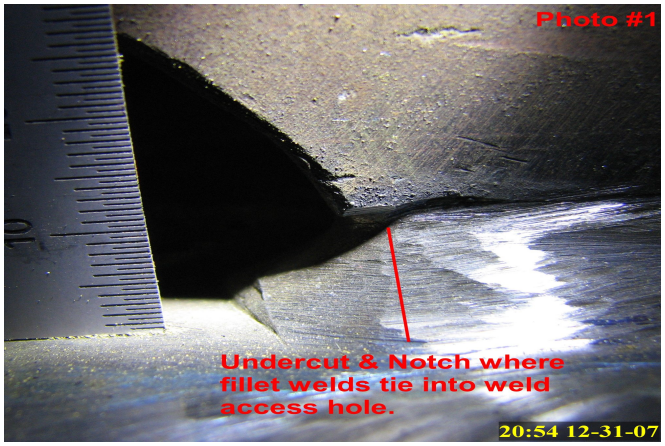
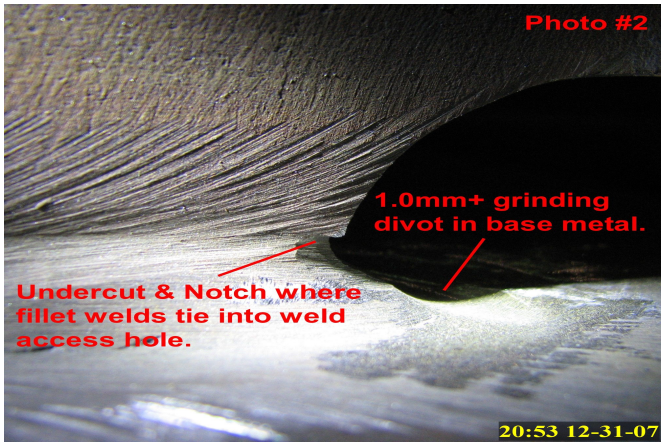
Rui is present and observing the welding of these joints. See the attached photo.







Summary of Conversations:

The QA inspector Scott Croff had conversations with the Quality Control Liaison (QCL) "Ken" Zhang Jiadi. The QA inspector was informed of the MT that was being conducted by ZPMC technician Zhou Dong Yun. The QA inspector was also informed of the status of work that was being conducted in Bay 7.

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations and conversations. The QA inspector also generated a summary report of these observations to be included in the daily shift notes. There were no other notable conversations during this shift.

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:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer