

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001158**Date Inspected:** 23-Dec-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**CWI Name:****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:** 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.

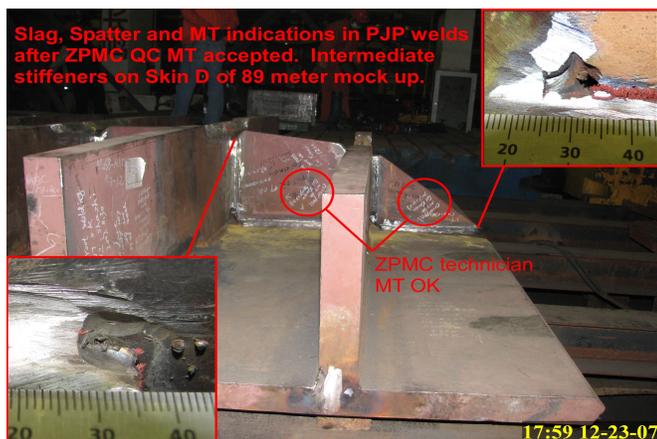
Bay 2: The QA inspector was informed that ZPMC's Quality Control (QC) inspection and Non-Destructive Examination (NDE) has been completed on the partial joint penetration (PJP) welds between the 40mm thick intermediate stiffeners, skin plates and skin plate stiffeners on the 89 meter mock up assembly skin plate "D". The QA inspector was informed that all of the welds were acceptable in their present condition. The QA inspector conducted random visual examination and magnetic particle testing of the completed and accepted PJP welds. The QA inspector noted that the welds appear to be non-conforming to the contract requirements at this time. The QA inspector noted that there appears to be slag, weld spatter and arc strikes that have not been removed from the welds and base metal as required by the contract documents. The QA inspector also noted that the PJP weld ends appear to have relevant MT indications. The QA inspector also noted that the PJP welds do not appear to be welded the full length of the prepared joints. The QA inspector was unable to continue the observations due to inclement weather and transportation from the work location was going to become unavailable. See the attached photo.

Bay 4: The QA inspector observed 3 ZPMC personnel grinding and examining SP010-01 fillet welds 015 thru 028. The QA inspector attempted to make random observations of the work in progress and identify the personnel working. Upon the QA inspector's arrival to this area, one of the ZPMC workers made a phone call, (the QA inspector could not determine the nature of the phone call) he then directed the others to stop their work and they

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left the area. The QA inspector was unable to identify if an approved CWI was involved in the observed work.



Summary of Conversations:

As noted above, the QA inspector Scott Croff was informed of the status of the 89 meter mock up, skin plate "D" and the intermediate PJP stiffener welds. The QA inspector was in the process of conducting verification of the welds and was informed that transportation from the work location was going to become unavailable due to inclement weather that was developing. The QA inspector then generated a summary report of the above mentioned 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
