

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001152**Date Inspected:** 02-Jan-2008**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:** Xu Xian Ping**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 3: The QA inspector observed several crews of ZPMC personnel fitting and tack welding T-stiffeners onto various side plate assemblies. The QA inspector was present in Bay 3 for a period of more than 45 minutes making random observations of the work in progress. The QA inspector was also attempting to identify the approved Quality Control (QC) CWI/CAWI personnel monitoring the work in progress. The QA inspector noted that tack welding is being performed by He Yu Mei, Li Meng Qian and Wei Dashuai. The QA inspector noted that welding parameters, preheat temperatures and locations are being monitored and recorded by ZPMC persons Huang Min and Wang Liang. The QA inspector was informed that the CWI Xu Xian Ping is monitoring the work in Bay 3. The QA inspector did not observe the CWI in Bay 3 while these observations were made. The QA inspector noted that the parts being fit up and tack welded include SP072-01 and SP019-91.

Bay 1: The QA inspector was directed to review the list of observed discontinuities that have been observed on the deck trial mock up. The QA inspector was provided with a list of the information that has so far been compiled. The QA inspector conducted visual examination of the 1.75 meter section of the deck trial, closed rib partial joint penetration (PJP) welds. The QA inspector relayed all of the observations and information to the QA inspectors Alfredo Acuna and Bruce Berger.

Summary of Conversations:

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As noted above, the QA inspector was directed to review the list of observations that have been made on the deck trial mock up. The QA inspector Scott Croff had conversations with the QA inspectors Alfredo Acuna and Bruce Berger in order to determine what needed review and modification on the composite list. The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations from Bay 3. 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
