

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-001325**Date Inspected:** 18-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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:	Check Samples	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

ZPMC personnel informed the QA Inspector there are seventeen steel plates for the 10th batch and two plates for the 25th batch, that are ready to have check samples taken for testing. The QA Inspector assigned the following lot numbers to nineteen check sample plates. All samples were a minimum of 460 mm long and 355 mm wide with the long axis perpendicular to the direction of roll. Sample number, thickness, direction of rolling, and QA Inspector's lot number were the only markings placed on check samples.

The following are a list for the 10th Batch.

Sample Number	Date	Heat Number	Plate Type/Grade	Thickness	Lot Number
130	1/18/2008	7200373N	A709M-345F2-X	28mm	B94-012-08
131	1/18/2008	7101157N	A709M-345F2-Z	45mm	B94-005-08
132	Void no samples taken				
133	1/18/2008	7200619N	A709M-345F2-X	28mm	B94-003-08
134	1/18/2008	7200699N	A709M-345F2-X	20mm	B94-009-08
135	1/18/2008	7200443N	A709M-345F2-X	20mm	B94-007-08
136	1/18/2008	7200977N	A709M-345F2-Z	28mm	B94-006-08

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137	1/18/2008	07200885	A709M-345F2-X	18mm	B94-011-08
138	1/18/2008	07200884	A709M-345F2-X	18mm	B94-015-08
139	1/18/2008	07302305N0	A709M-345F2-X	12mm	B94-004-08
140	1/18/2008	7302160N	A709M-345F2-X	28mm	B94-010-08
141	1/18/2008	07302672N0	A709M-345F2-X	18mm	B94-014-08
142	1/18/2008	07302158N0	A709M-345F2-X	18mm	B94-025-08
143	1/18/2008	7200090N	A709M-345F2-Z	16mm	B94-022-08
144	1/18/2008	07302674N0	A709M-345F2-X	14mm	B94-021-08
145	1/18/2008	07302450N0	A709M-345F2-X	16mm	B94-020-08
146	1/18/2008	7301351N	A709M-345T2-X-S	14mm	B94-013-08
147	1/18/2008	07101149N	A709M-345F2-Z	90mm	B94-024-08

The following are a list for the 10th Batch.

176	1/18/2008	07302354N0	A709M-345F2-X	16mm	B94-008-08
177	1/18/2008	07301492N0	A709M-345F2-X	16mm	B94-023-08

Summary of Conversations:

No conversations spoken.

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:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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