

**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-001618**Date Inspected:** 19-Feb-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:** Cui Yi Ru**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:** OBG**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.

Caltrans Quality Assurance (QA) Inspector McClendon observed ZPMC welding various floor beam fillet welds that are continuous which were previously terminated at hold back areas. This observation was brought to the attention the QA Inspectors Task Leader and the island Assistant Structural Materials Representative. ZPMC was observed fitting up various stiffeners to the floor beam web plates. The Caltrans QA Inspector has observed that there are 28 floor beams that have stiffener plates applied on two thicknesses of web plates. The stiffener plate at the web plate change of plate thickness junction has been coped out and there is no continuous fillet weld as detailed in the approved drawings. Caltrans QA Inspector has generated an Incident Report number 04-0120F4\_15-SAS-B94-02-19-2008 pertaining to plate stiffeners on several floor beams that are required to have a continuous fillet weld along the length of the stiffener to the web plate that transitions from one thickness to a thinner thickness. See the included digital picture of the discrepancy.

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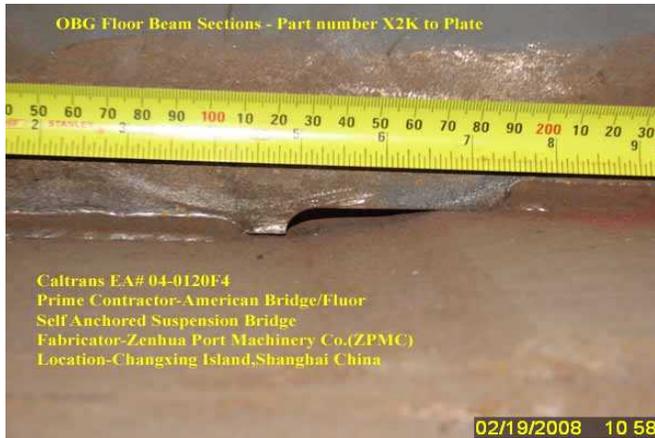
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations spoken on this date.

## 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.

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<b>Inspected By:</b>	McClendon,Timothy	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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