

**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-001549**Date Inspected:** 03-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>				<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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.

The QA inspector performed visual weld inspection on the following welds on production panel DP-072-001, weld # 6 on rib # U6 three (3) areas of under filled welds totaling 71 mm and two (2) areas of oversize weld totaling 50mm, weld # 7 on rib # U29 two (2) areas of underfilled weld was found totaling 115mm, weld # 8 on rib # U29 two (2) areas of underfilled weld was found totaling 10mm, weld #9 on rib # U76 two areas of oversize weld was found totaling 85mm and one (1) area of incomplete fusion was found totaling 6mm and one (1) area of underfilled weld totaling 40mm, weld # 10 on rib #U76 four (4) areas of underfilled weld totaling 61mm and three (3) areas of overlap totaling 455mm. The QA inspector also performed visual weld inspection on the following welds on production panel DP-070-001, weld # 6 on rib # U49 two (2) areas of under filled weld totaling 30mm, four (4) areas of incomplete fusion was found totaling 55mm and one area of incomplete penetration was found totaling 10mm, weld # 7 on rib # U33 two (2) areas of oversize weld was found totaling 37mm, one (1) area of incomplete fusion was found totaling 7mm and one (10 area of over lap was found totaling 35mm, weld # 8 on rib # U33 one (1) areas of oversize weld was found totaling 35mm three (3) areas of incomplete fusion was found totaling 20mm and three (3) areas of underfilled weld was found totaling 106mm, weld #9 on rib # U41 one (1) area of underfill was found totaling 6mm and one area of incomplete fusion was found totaling 5mm.

Visual Tracking Record is being maintained on site for reference and has been forwarded to the assistant structural materials representative Mr. Ady Velasco.

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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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