

**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-002413**Date Inspected:** 03-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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

**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

**Production Monitoring Tests Macro Etches**

The Quality Assurance Inspector performed a visual inspection of two sets of production monitoring tests (PMT) macro etch samples, identified as DP-113-001/DP-015-001 and DP-084-001/DP-220-001. The PMT's were welded on 5-02-2008 and 4-28-2008. All samples appeared to contain penetration greater than 80 percent. For DP-113-001/DP-015-001 the Quality Assurance Inspector observed one sample that contained non-compliant incomplete fusion and one sample that contained a compliant linear indication. For DP-084-001/DP-220-001, the Quality Assurance Inspector observed one sample that contained incomplete fusion deemed non compliant and two samples containing linear indications. All the data from the review was recorded in a tracking log and forwarded to Quality Assurance Task Leaders and Structural Materials Representatives. The Samples were digitally photographed and placed on the internal server for future review.

**Summary of Conversations:**

As stated in the contents of the above report.

**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 Pat Lowry, (916) 227-5719, who represents the Office of Structural Materials for

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# WELDING INSPECTION REPORT

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your project.

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**Inspected By:** Bertlesman, Greg

Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert

QA Reviewer