

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-002772**Date Inspected:** 03-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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:	Skin Plate	

Summary of Items Observed:

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

CWI Inspector: NA No welding observed

This inspector randomly observed CNC thermal cutting & Horizontal Milling on various skin plates and stiffeners in tower heavy shop bay# 2.

This Inspector performed Magnetic Particle Testing (MT) verification of the QC MT Inspected and accepted welds. QA Inspector's MT verification appears to be acceptable with AWS D1.5-02 section 6.26.2.1 & 6.26.2.3 Reference QA Magnetic Particle Test Report TL-6028 dated 6-3-08 for specific test data.

Summary of Conversations:

This inspector spoke directly with QC lead inspector (Tom) Li Xiu Yang about the difficulty locating several floor beams and skin plates for UT QA verification per notification list 00476 & 00475. According to the QC inspector the floor beams and skin plates were not in any tie over log or noted otherwise that the QC inspector could locate. The QC inspector was unable to offer this inspector any help or information in locating the listed welds for NDT per previous mentioned notification list. The QC inspector explained that he had no information available for

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himself and was not able to assist this inspector. A few of the welds that were located were not signed off by the QC UT technician and the QC lead inspector had no explanation for this condition as well.

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 Patrick Lowry 858-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
