

**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-000875**Date Inspected:** 14-Nov-2007**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

<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>	Box Girder Mock Up	

**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction of the 13 meter long deck section for the SAS Superstructure.

The QA inspector arrived at the fabrication facility and met with the QA inspector Robert Cuellar and Alfredo Acuna. The QA inspector was informed of the locations of work being performed at this time. The QA inspectors Scott Croff and Alfredo Acuna went to Bay 1 and made random observations of the closed rib welds on the deck mock up. The QA inspector Scott Croff was informed of the status of the 1st and 2nd mock up and the partial joint penetration (PJP) welds. See the attached photo.

The QA inspector Scott Croff assisted the QA inspectors Robert Cuellar and Alfredo Acuna in conducting a visual examination of the closed rib PJP welds on the 1st 13 meter deck mock up. The QA inspector noted that Art Peterson, Peter Ferguson and Craig Knops of American Bridge/Fluor (ABF) were present and also conducting the visual examination of the closed rib PJP welds. The QA inspector measured and recorded dimensional observations and measurements of observed weld overlap. The recorded information was reported to the QA inspector Alfredo Acuna.

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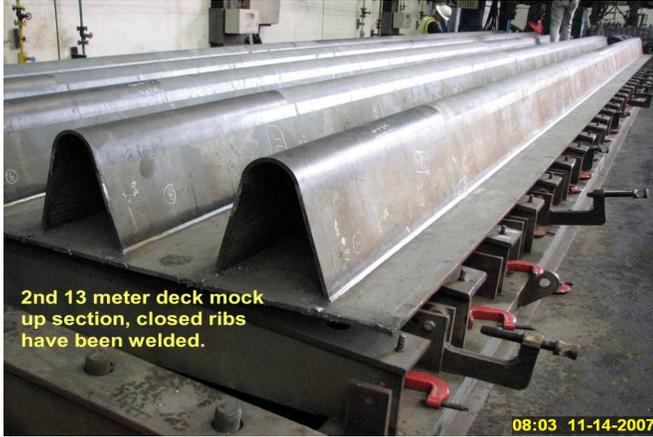
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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QA inspector Scott Croff had conversations with the QA inspectors Robert Cuellar and Alfredo Acuna regarding the locations and status of work. As noted in the Summary of Observations, the QA inspector Scott Croff was present during the examination of the closed rib PJP welds. The QA inspector was informed of measurements for notation that the ABF personnel and QA inspectors observed during the examination and light leak tests of the closed rib PJP welds. Upon completion of the light leaks, the recorded information was given to the QA inspectors Robert Cuellar and Alfredo Acuna. There were no other notable conversations during this shift.

## 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>	Croff,Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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