

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-000964**Date Inspected:** 29-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Fu Guo Gang	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:	89 Meter Mock-Up	

Summary of Items Observed:

Mock-Up 89

This Quality Assurance Inspector witnessed ZPMC magnetic particle technicians Zhou Dong Yin and Cai Xinxin performing magnetic particle testing of the cover passes of the welds for MUSB-MA26-27A/B; 27A-1/B-1; 10A/B; 9A-1/B-1; 10A-1/B-1; 9A;9B & MUSB-MA25-6A/6B & 15A/B. A discussion was held with (Ken) Zhang Jiadi and Shen Xiu Jun concerning the testing carried out by ZPMC magnetic particle technicians. No attempt was made by ZPMC to inspect the weld ends where run of tabs had been removed and in some case a where a machined weld bevel was put on the edge of the plate. This Quality Assurance Inspector did not perform 10% verification testing on these welds as the ends of the welds were not visually inspected or magnetic particle tested by ZPMC so testing was not complete. Also during the testing it was pointed out to Zhang Jiadi and Shen Xiu Jun that they were losing traceability of the material as the white tags were ripped and fading as was the writing on the plates themselves. In one case a plate had two separate numbers, one a M25 number and the other a MA26 number. It took production and quality control sometime to figure out which plate it was. There were several other plates which the numbers could not be found on due to the where fading and rubbing of one the marked surfaces.

Summary of Conversations:

As noted above.

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

WELDING INSPECTION REPORT

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
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Reviewed By:	Cochran, Jim	QA Reviewer
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