

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-000975**Date Inspected:** 04-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**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:	Lay Tau			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:	114 meter mock up assembly		

Summary of Items Observed:

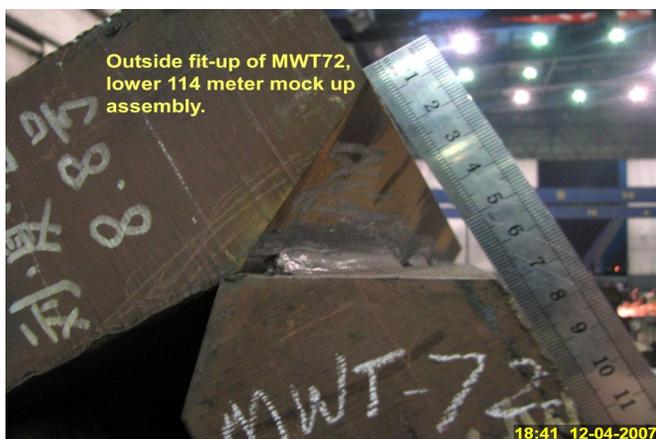
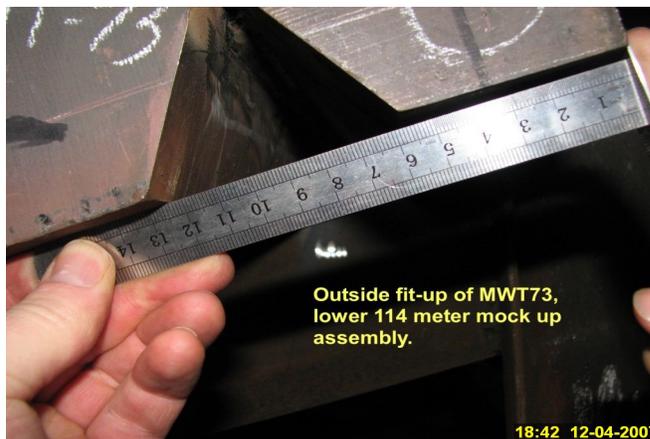
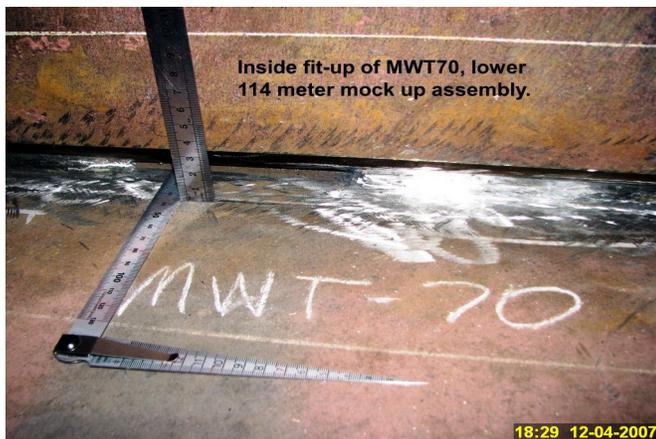
The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

The QA inspector made random observations of fit-up of weld joints MWT70, MWT71, MWT72, MWT73 and MWT74 as they were being prepared on the lower 114 meter mock up assembly. The QA inspector observed that the bevel depths appear to be corresponding with the approved weld details. The QA inspector was unable to accurately observe the bevel angles of the weld joints. The QA inspector noted that all root openings appear to be 0mm at this time. The Quality Control Liaison (QCL) Lay Tau accompanied the QA inspector while these observations were being made. The QCL informed the QA inspector that ZPMC workers were still making dimensional verifications of the assembly. The QA inspector also observed that no weld tabs are currently attached at any of the ends of the complete joint penetration (CJP) welds. See the attached photos of some of these observations.

The QA inspector observed ZPMC workers excavating weld metal on 114 meter connection plate MUC-A75. The QA inspector was informed that critical weld repair (CWR)-26 is documenting this work. The QA inspector confirmed the approved CWR for this observed work. The QA inspector was informed that the repair will not be ready for welding during this shift.

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Summary of Conversations:

As noted above, the QA inspector Scott Croff had conversations with the QCL Lay Tau regarding the status of the lower 114 meter mock up assembly. The QA inspector was informed that weld tabs will be placed later and the assembly will not be welded in its current position. The QA inspector was shown the area of Bay 2 where a frame is set up to position the assembly for welding. The QA inspector was also informed that final dimensional checks and fit-up will take place when the assembly is moved to the welding location. 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.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer