

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-001038**Date Inspected:** 03-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Zhong**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:** Caltrans Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

The Caltrans QA Inspector received the plate material list for Batch No. 43. The following thirty-two (32) plate Nos. from the production plate list were observed: 2814, 2815, 2816, 2818, 2819, 2820, 2821, 2826, 2838, 2839, 2840, 2841, 2843, 2844, 2846, 2847, 2848, 2851, 2875, 2877, 2882, 2888, 2894, 2895, 2896, 2897, 2898, 2899, 2900, 2913, 2914, 2915. The plates were observed for their general condition and identification marking, including accurate transfer of original manufacturer's required identification. The plates were designated as ASTM A709M-345T2-X and ASTM A709M-345F2-X and ranged in thickness from 12 mm to 35 mm. The QA Inspector assigned Lot No. B93-013-07 to these thirty-two plates on Batch No. 43.

The QA Inspector also observed one hundred (100) pieces of ASTM A500 Grade B, 300 mm x 300 mm x 10 mm square tubing for identification marking and general condition. There were fifty (50) pieces identified as Heat No. 073754 and fifty (50) pieces identified as Heat No. 073755. The QA Inspector observed that the original manufacturer's identification was still legible on each piece. In addition, this information had been transferred to the inside of each tube on one end. See attached picture showing typical identification. The QA Inspector assigned Lot No. B93-011-07 to Heat No. 073755 and Lot No. B93-012-07 to Heat No. 073754.

The QA Inspector was accompanied by ZPMC Quality Assurance Representatives, Mr. Sun Bo and Mr. Xu Jun, during these observations.

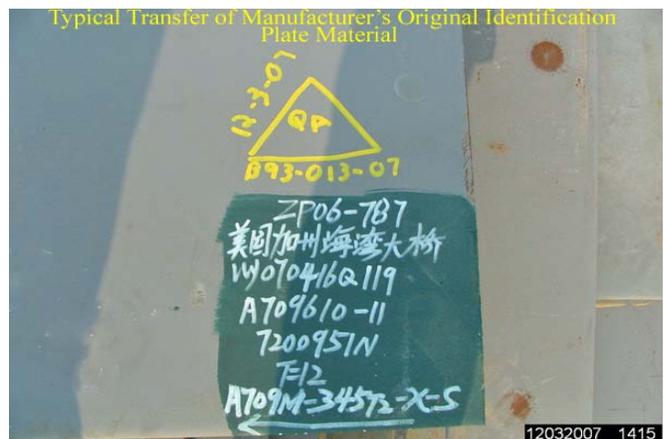
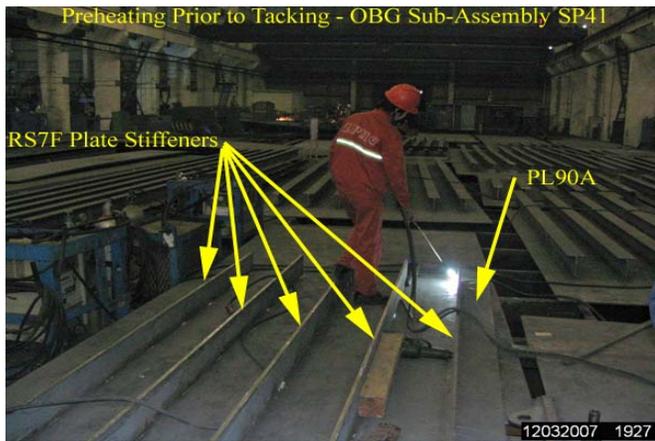
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The QA Inspector observed the tacking of RS7F plate stiffeners to Piece Mark PL90A to make up Side Plate Sub-Assembly as shown on Drawing No. SP41. The QA Inspector observed that the material was being preheated and that the tack welder was Wang Zhonghua (I. D. No. 053753), whose qualifications for this welding are listed in ZPMC's Master List of Welders/Welding Operators/Tack Welders, Revision 6. The Welding Procedure Specification (WPS) was WPS-B-P-2212-SMAW, which specified the electrode as TL508 (E7018), which was being used for this tacking.

The QA Inspector also observed the machine Submerged Arc Welding (SAW) of Weld No. FB-001-02-021, which joins Piece Mark X14A to a sub-assembly of Piece Marks X46A and X46D (previously welded). This is on the OBG. The welding operator was Huang Xinian (I. D. 044780), whose qualifications for this welding are listed in ZPMC's Master List of Welders/Welding Operators/Tack Welders, Revision 6. ZPMC CWI, Zhang Zhong (AWS CWI No. 07051341) was present during this welding.

All observations appeared to meet the requirements of the job specifications.



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Summary of Conversations:

As identified within the contents of this 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Jobs, Kenneth	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
