

**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-001079**Date Inspected:** 04-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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>	Plate material	

**Summary of Items Observed:**

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

**Plate Material Storage Yard:**

Quality Assurance (QA) Inspector Brannon received plate material list for batch #43, production plate list No. 1813~2909 received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC material storage yard accompanied by ZPMC Quality Control Mr. Zhang Jiada. QA Inspector Brannon observed a total of 69 out of 109 plates for batch #43. The plates were observed for their general condition and markings. Plate material thicknesses range from 12mm to 35mm. The plates were designated as A709M-345T2, A709M-345T2-X, A709M-345F2-X and A709M-345T2-X-S. Plate material list for batch #43 was accompanied with material test reports (MTR's). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector Brannon assigned lot number B22-060-07 to the 69 plates observed on this date. Note: Plate number 2881 was not accepted by QA Inspector Brannon due to edge distortion in many locations approximately 30mm to 60mm in from the edges of the plate.

The following digital photograph below illustrates observation of the activities being performed.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Summary of Conversations:

No relevant conversations on this date.

## 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>	Brannon, Sherri	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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