

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-001123**Date Inspected:** 10-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:** Li Xiu Yang**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.

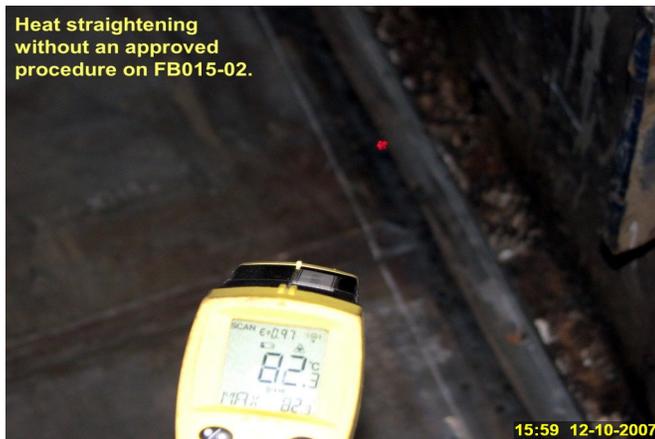
At the beginning of the shift, the QA inspector was informed that there were completed welds that have been inspected by ZPMC's Quality Control (QC) inspectors and Non-Destructive Examination (NDE) technicians. The QA inspector was directed to verify that these welds were conforming to the contract requirements. The QA inspector contacted the QC Liaison "Tom" Li Xiu Yang upon arrival to Bay 2. The QA inspector and the QC Liaison were unable to locate any welds that could be identified as completed, accepted and ready for QA verification. The QC Liaison informed the QA inspector that ZPMC technician Cai Xin Xin will be conducting magnetic particle testing (MT) on the upper 114 meter mock up assembly. The QA inspector was informed that temporary lifting lugs have been removed, the temporary welds have been ground flush and will be inspected with MT. The QA inspector was informed that 15 total areas will be inspected. The QA inspector then witnessed Cai Xin Xin conduct MT on 4 of the 15 areas. At the time of observation, the QA inspector noted that several of the areas to be inspected still appear to have carbon arc slag and weld metal that has not yet been ground flush.

Bay 7: The QA inspector observed ZPMC workers straightening floor beam diaphragm assembly (FB)015-02. The QA inspector noted that a large weight is being used to restrain the part while heat has been applied along weld seams. The QA inspector did not observe any torches being used, however, the QA inspector noted that a torch was laying near by and a temperature gun measured 82.3°C along the weld.

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Bay 1: The QA inspector assisted the QA inspector Bruce Berger to conduct measurements of the close ribs from actual center line on the deck trial mock up assembly.



Summary of Conversations:

As noted above, the QA inspector Scott Croff had conversations with the Quality Control Liaison (QCL) "Tom" Li Xiu Yang regarding welds that the QA inspector was attempting to locate. The QCL was asked if he could communicate with other ZPMC personnel to locate these welds. The QA inspector was informed that they (ZPMC personnel in Bay 2) were not aware of any parts ready for QA verification at this time.

The QA inspector Scott Croff assisted the QA inspector Bruce Berger with the measurement of closed ribs on the deck trial mock up assembly. The QA inspector Bruce Berger was also informed of the other mentioned observations and conversations. The QA inspector then generated a summary report to be included in the daily shift notes. 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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Inspected By:	Croff, Scott	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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