

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001125**Date Inspected:** 07-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:** Zhu Zhong Hai**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.

Bay 2: The QA inspector observed ZPMC welding temporary lifting lugs onto the lower 114 meter mock up assembly. The QA inspector noted that "Quality Control" (QC) person Chen Hau is monitoring the shielded metal arc welding (SMAW) of these temporary lifting lugs. The QA inspector reviewed the approved list of CWI/CAWI QC personnel and could not identify this "QC" person as being approved by the Engineer. The QA inspector noted that approved CWI Zhu Zhong Hai is across bay 2 near work that is being conducted on MUSC-A58.

The QA inspector observed ZPMC personnel working on part MUSC-A58. The QA inspector noted that weld metal is being excavated. The QA inspector asked the CWI Zhu Zhong Hai what work was being done. The QA inspector was informed that critical weld repair (CWR) 29 was being excavated.

Bay 7: The QA inspector observed ZPMC workers fitting floor beam diaphragm (FB) components together and preparing to tack weld the assembly. The QA inspector randomly observed weld joint 004 of several floor beam assemblies. The fit up preparations that were observed by the QA inspector appeared to be conforming to the contract requirements. The QA inspector did not observe the final fit-up of these parts. The QA inspector observed a ZPMC crew checking the flatness of weld 026 and their associated plates on FB008-01. The QA inspector noted that the plates appear to have significant distortion but there was no immediate access to measure these observations.

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Summary of Conversations:

The QA inspector Scott Croff had conversations with the Quality Control Liaison (QCL) "Tom" Li Xiu Yang, regarding the observations of work that were made in Bay 2. The QCL Tom was interpreting the questions being asked by the QA inspector, and conversations are described above.

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above 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.

Inspected By:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
