DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-001129
Date Inspected: 07-Jan-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 630
OSM Departure Time: 1530
Location: Shanghai, China

CWI Name: ZPMC- Du Wen Ling and Xie Ping

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: Closed U-rib Macro Etch samples

Summary of Items Observed:

On this date, the Caltrans Quality Assurance (QA) representative, John P. Tracy, conducted assessments while on site at Zhenhua Port Machinery Company (ZPMC) for Caltrans Project 04-0120F4-SAS. The following is the detailed review of the following observations:

Thirty separate sample areas were chosen from the number one deck mock-up based on Ultrasonic Testing (UT) inspection data and Visual Testing (VT) inspection in order to produce macro etch samples. ZPMC personnel then removed areas of interest where they then prepped and polished each component. The Caltrans representative was notified of the completed polishing operation and observed these samples in the ZPMC mechanical laboratory.
At 1520 the Caltrans representative was notified that the samples had completed the macro etch process and were ready for initial inspection. The thirty completed samples, American Bridge Fabricator (ABF) representative, Mr. Art Peterson, and ZPMC Quality Control (QC) personnel, Du Wen Ling and Xie Ping, were already present when the Caltrans inspector arrived.
Mr. Peterson inspected the samples for clarity and definition. He expressed that they appeared to be in accordance with inspection criteria. Eight random samples were viewed by the Caltrans representative. Defined penetration boundaries and weld nugget profiles were clearly visible.
Testing for depth of penetration and visual criteria was discussed and to begin at 0900 on 01/08/2008 with the three representatives present plus a ZPMC Certified Welding Inspector (CWI).
Mr. Peterson told the Caltrans representative that the samples would be delivered to Caltrans personnel at approximately 1300 on 01/08/2008. The Caltrans representative notified his task leader at 1550 on this date for turn-over purposes.

WELDING INSPECTION REPORT

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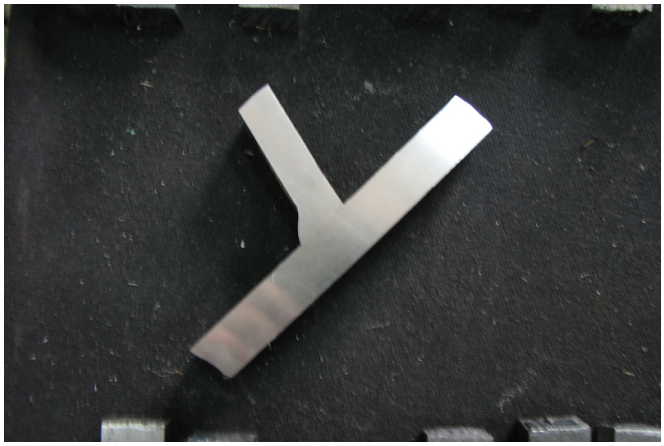
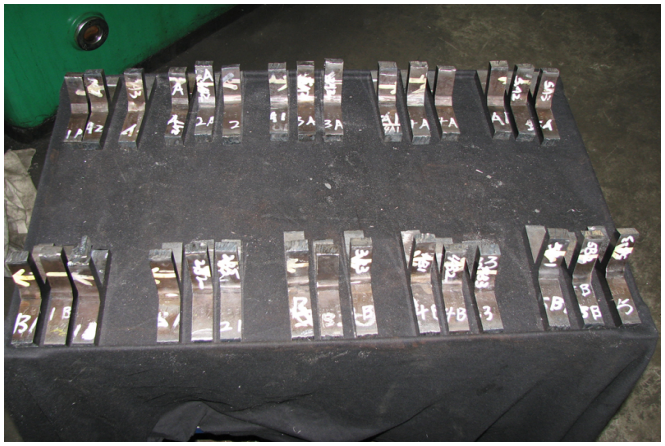
Included below are digital pictures that support the observations recorded within this report.





Summary of Conversations:

The Caltrans representative had discussions with Mr. Mike Williams, of ABF, in order to obtain closure from the issues pertaining to CWR(CT)032 on the 114m lower mock-up section. He relayed to the Caltrans representative that the issue had been resolved through the proper Caltrans engineering protocol.

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:	Tracy,John	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer