

**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-001151**Date Inspected:** 03-Jan-2008**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:****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:** Tower Mock Ups, OBG components**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.

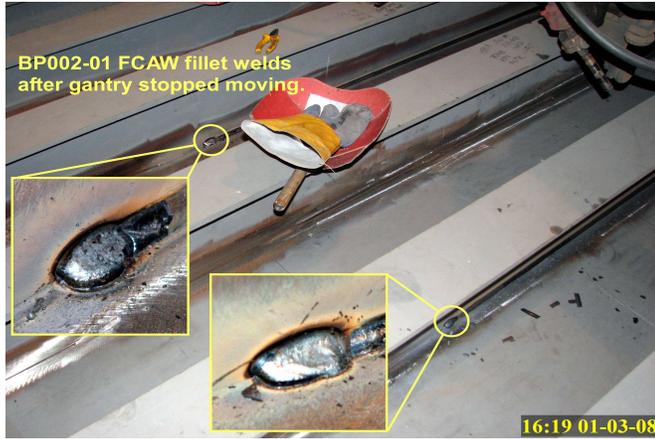
Bay 3: The QA inspector observed ZPMC personnel operating the gantry mounted flux cored arc welding (FCAW) to make fillet welds on BP002-01. The QA inspector observed 3 welders, each operating 2 machines. The QA inspector was informed that the welders were Li Zhou Qian, Xin Meng and Li Shu Liang. The QA inspector observed that joints being welded were 010, 011, 014, 015, 018 and 019. The QA inspector was making random observations of the welding when the QA inspector was alerted by a ZPMC worker yelling at the welders. The QA inspector observed that the gantry had stopped moving forward. The QA inspector observed that the gantry has struck a preheat controller unit that was in the traveling path of the gantry. Several of the FCAW welds were not terminated when the forward motion of the gantry stopped. The QA inspector observed that large weld puddles were deposited where the FCAW welds ended at 010, 011 and 014. During the welding operation, the QA inspector was unable to identify if an approved CWI/CAWI was present and after the sudden stoppage of the welding, the QA inspector observed several ZPMC persons leave the work area. The QA inspector attempted to observe any corrective actions that were being taken. The QA inspector measured the weld length to be approximately 3500mm before the gantry motion was halted. The QA inspector returned to this work area several other times through out the shift but there no noticeable progress at this location. See the attached photos.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Summary of Conversations:

The QA inspector Scott Croff informed the QA inspector Bruce Berger of the above mentioned observations in Bay 3. The QA inspector also generated a summary report of these observations 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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<b>Inspected By:</b>	Croff,Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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